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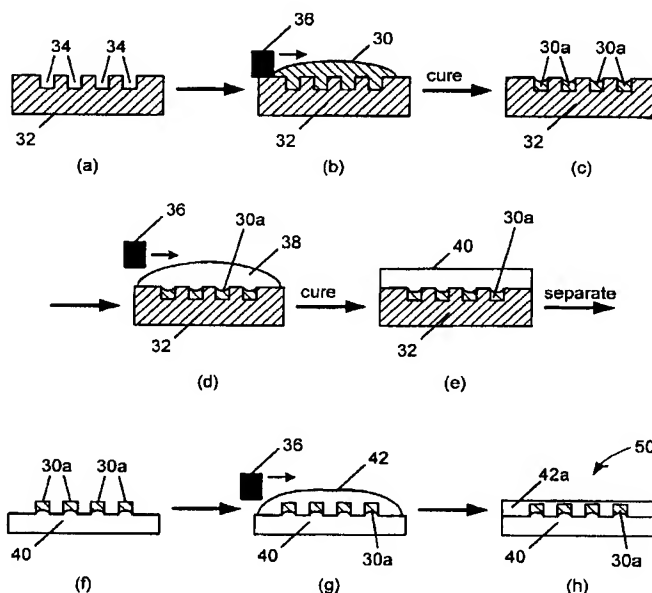
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(54) Title: **POLYMERIC COMPOSITIONS FOR FORMING OPTICAL WAVEGUIDES; OPTICAL WAVEGUIDES FORMED THEREFROM; AND METHODS FOR MAKING SAME**



(57) Abstract: The present invention relates to polymer compositions and methods of polymerizing such compositions. Furthermore, the present invention relates to polymer compositions that are useful in forming waveguides and to methods for making waveguides using such polymer compositions.



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5 Title: **POLYMERIC COMPOSITIONS FOR FORMING OPTICAL
WAVEGUIDES; OPTICAL WAVEGUIDES FORMED THEREFROM;
AND METHODS FOR MAKING SAME**

RELATED APPLICATION DATA

10 This application claims priority to previously filed U.S. Provisional
Application No. 60/221,420, filed on July 28, 2000, entitled "Polymeric
Compositions for Forming Optical Waveguides; Optical Waveguides Formed
Therefrom; and Methods for Making Same", and U.S. Provisional Application No.
15 60/252,251, filed on November 21, 2000 entitled "Polymeric Compositions for
Forming Optical Waveguides; Optical Waveguides Formed Therefrom; and
Methods for Making Same", both of which are incorporated herein by reference in
their entireties.

FIELD OF THE INVENTION

20 The invention herein described relates generally to polymeric
compositions for forming optical waveguides and methods for forming such
optical waveguides using the same. In particular, the present invention relates to
polymers made from at least one cyclic olefin monomer which can be used to
form optical waveguides using either a clad-first or core first technique.

BACKGROUND OF THE INVENTION

25 The demand for continuous increase in transmission speed, data capacity
and data density in integrated optical and optoelectronic circuits has been the
motivating force behind numerous innovations in areas of broadband
30 communications, high-capacity information storage, and large screen and
portable information display. Although glass optical fibers are routinely used for
high-speed data transfer over long distances, they are inconvenient for complex
high-density circuitry because of their high density, poor durability and high cost

of fabrication for complex photonic circuits. As such, polymeric materials hold great promise for constructing cost effective, reliable, passive and active integrated components capable of performing the required functions for integrated optics.

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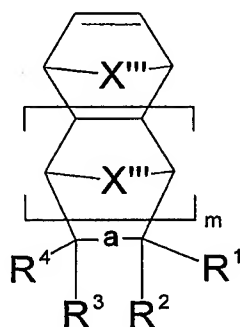
SUMMARY OF THE INVENTION

The present invention relates generally to polymeric compositions for forming optical waveguides and methods for forming such optical waveguides using the same. In particular, the present invention relates to polymers made from at least one cyclic olefin monomer which can be used to form optical waveguides using either a clad-first or core first technique.

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In one embodiment, the present invention relates to polycyclic polymer compositions formed from one or more monomers or oligomers represented by the following structure:

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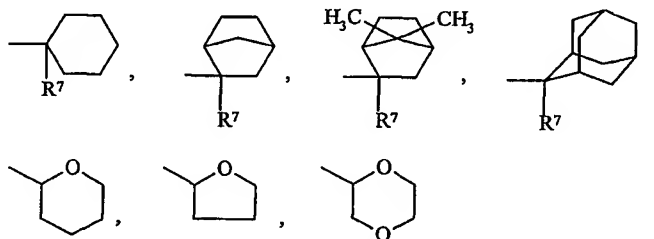
wherein each X''' independently represents oxygen, nitrogen, sulfur, or a methylene group of the formula $-(CH_2)_{n'}$ where n' is an integer of 1 to 5; "a" represents a single or double bond; R^1 to R^4 independently represent a hydrogen, a hydrocarbyl, or a functional substituent; and m is an integer from 0 to 5, with the proviso that when "a" is a double bond one of R^1 , R^2 and one of R^3 , R^4 are not present.

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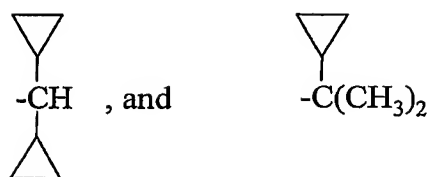
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In another embodiment, R^1 to R^4 independently comprises a hydrocarbyl, a halogenated hydrocarbyl or a perhalogenated hydrocarbyl group which are selected from: i) linear or branched C_1 - C_{10} alkyl groups; ii) linear or branched C_2 - C_{10} alkenyl groups; iii) linear or branched C_2 - C_{10} alkynyl groups; iv) C_4 - C_{12} cycloalkyl groups; v) C_4 - C_{12} cycloalkenyl groups; vi) C_6 - C_{12} aryl groups; and vii) C_7 - C_{24} aralkyl groups, provided that at least one of R^1 to R^4 is a hydrocarbyl group.

In another embodiment, one or more of R^1 to R^4 represent a functional substituent independently selected from $-(CH_2)_n-CH(CF_3)_2-O-Si(Me)_3$, $-(CH_2)_n-CH(CF_3)_2-O-CH_2-O-CH_3$, $-(CH_2)_n-CH(CF_3)_2-O-C(O)-O-C(CH_3)_3$, $-(CH_2)_n-C(CF_3)_2-OH$, $-(CH_2)_n-C(O)NH_2$, $-(CH_2)_n-C(O)Cl$, $-(CH_2)_n-C(O)OR^5$, $-(CH_2)_n-OR^5$, $-(CH_2)_n-OC(O)R^5$, $-(CH_2)_n-C(O)R^5$, $-(CH_2)_n-OC(O)OR^5$, $-(CH_2)_nSi(R^5)_3$, $-(CH_2)_nSi(OR^5)_3$, $-(CH_2)_n-O-Si(R^5)_3$, and $-(CH_2)_n-C(O)OR^6$, wherein n independently represents an integer from 0 to 10, R^5 independently represents a hydrogen, a linear or branched C_1 - C_{20} alkyl group, a linear or branched C_1 - C_{20} halogenated or perhalogenated alkyl group, a linear or branched C_2 - C_{10} alkenyl group, a linear or branched C_2 - C_{10} alkynyl group, a C_5 - C_{12} cycloalkyl group, a C_6 - C_{14} aryl group, a C_6 - C_{14} halogenated or perhalogenated aryl group and a C_7 - C_{24} aralkyl group; and R^6 is selected from $-C(CH_3)_3$, $-Si(CH_3)_3$, $-CH(R^7)OCH_2CH_3$, $-CH(R^7)OC(CH_3)_3$ or one of the following cyclic groups:



or one of the following:



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wherein R^7 represents a hydrogen or a linear or branched ($C_1 - C_5$) alkyl group.

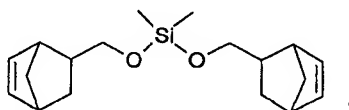
In still another embodiment, a polymer composition in accordance with the present invention is formed from one or more monomers or oligomers as described herein in combination with one or more crosslinking agents.

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Furthermore, in still another embodiment, the one or more crosslinking agents are latent crosslinking agents.

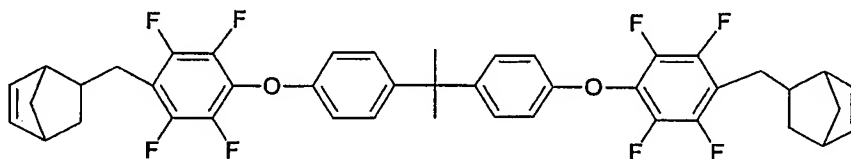
In one embodiment, the at least one crosslinking agent can be the compound shown below:

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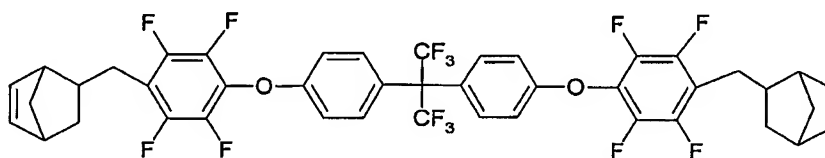
In yet another embodiment, the one or more crosslinking agents are represented by one or more of the following structures:

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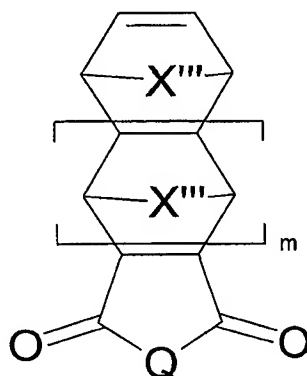


and

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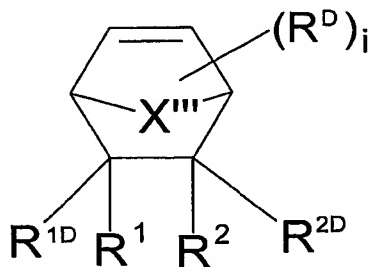


In yet another embodiment, the present invention relates to polycyclic polymer compositions formed from one or more monomers or oligomers represented by the following structure:



wherein each X''' independently represents oxygen, nitrogen, sulfur, or a methylene group of the formula $-(CH_2)_{n'}$ where n' is an integer of 1 to 5; Q represents an oxygen atom or the group $N(R^8)$; R^8 is selected from hydrogen, a halogen, a linear or branched C_1 - C_{10} alkyl, and C_6 - C_{18} aryl; and m is an integer from 0 to 5.

In yet another embodiment, a polycyclic polymer composition formed from one or more monomers represented by the following structure:



wherein X''' represents oxygen, nitrogen, sulfur, or a methylene group of the formula $-(CH_2)_{n'}$ where n' is an integer of 1 to 5; R^D is deuterium, "i" is an integer ranging from 0 to 6, with the proviso that when "i" is 0, at least one of R^{1D} and R^{2D} must be present; R^1 and R^2 independently represent a hydrogen, a hydrocarbyl,

or a functional substituent; and R^{1D} and R^{2D} , which are optional, independently represent a deuterium atom or a deuterium enriched hydrocarbyl group containing at least one deuterium atom.

5 In another embodiment, a polymer composition for use in a waveguide is produced from one or more monomers or oligomers described.

In still another embodiment, a polymer composition according to the present invention further includes at least one crosslinking agent. In one embodiment, the crosslinking agent is a latent crosslinking agent.

10 The present invention is advantageous in that it provides polymer compositions which permit the formation of optical waveguides having better performance qualities such as, for example, a difference (Δn) in the refractive index of the core material versus that of the clad material of at least about 0.00075 (i.e., at least about 0.05% where the clad or cladding material has a refractive index of about 1.5) for over a broad wavelength range (e.g., about 400
15 to about 1600 nm); lower intrinsic optical loss (lower than about 1 dB/cm and in some cases lower than about 0.5 dB/cm); a high glass transition temperature (T_g) (e.g., in one embodiment at least about 150 °C, in another embodiment at least about 250 °C, and in some cases at least about 280 °C).

20 Additionally, the present invention is advantageous in that it provides core and/or cladding compositions which can have a low viscosity or viscosities so as to be deliverable by any suitable technique, including ink jet printers, screen printers or stencil printers. Furthermore, the disclosed core-first method for forming optical waveguides is advantageous in that it permits the formation of optical waveguides with a reduction and/or elimination in the occurrence of
25 "swelling" between layers (see Figures 5A and 5B for a photographic depiction of "swelling"). Thus, the core-first method permits the formation of improved waveguides.

30 The foregoing and other features of the invention are hereinafter fully described and particularly pointed out in the claims, the following description and the annexed drawings setting forth in detail one or more illustrative embodiments

of the invention, such being indicative, however, of but one or a few of the various ways in which the principles of the invention may be employed.

BRIEF DESCRIPTION OF THE DRAWINGS

5 Figure 1 is a step diagram of the steps of a clad-first waveguide formation method;

 Figures 2A to 2C depict waveguide structures formed using the clad-first method of Figure 1;

10 Figure 3 is a step diagram of the steps of a core-first waveguide formation method of the present invention;

 Figures 4A to 4D are another set of waveguides formed using the core-first method of the present invention;

15 Figures 5A and 5B are photographs comparing the clad-first waveguide forming method of Figure 1 to the core-first waveguide forming method of Figure 3;

 Figure 6 is a step diagram of the steps of a modified core-first waveguide formation method of the present invention;

 Figures 7A and 7B are optical micrographs depicting a waveguide formed in accordance with the methods of Figures 3 and 6, respectively;

20 Figure 8 is a step diagram of the steps of a method for forming isolate-buried channel waveguides by cutting multi-layer films; and

 Figures 9A to 9D depict waveguide structure formed using the multilayer method of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

25 As stated above, the present invention relates to a variety of methods which can be used to form optical waveguides, and more specifically to form optical waveguides having buried channels. Also, the present invention relates to compositions which can be used to form optical waveguides.

It should be noted that in the following text and claims, range and ratio limits and/or range and time limits may be combined. Additionally, as used throughout the specification and claims the terms core composition and cladding (or clad) composition are defined to mean one of the following:

- (1) a composition which includes at least one monomer;
- (2) a composition which includes at least one monomer and at least one oligomer, where the total amount of reactive monomer and/or reactive oligomer is at least about 30 weight percent based on the total weight of either the core or cladding composition;
- (3) a composition which includes at least one monomer and at least one polymer, where the total amount of reactive monomer is at least about 30 weight percent based on the total weight of either the core or cladding composition; and
- (4) a composition which includes at least one monomer, at least one oligomer and at least one polymer, where the total amount of reactive monomer and/or reactive oligomer is at least about 30 weight percent based on the total weight of either the core or cladding composition. Oligomer as used throughout the specification and claims is defined to mean a composition containing less than about 1000 repeating units of a given monomer.

Furthermore, the refractive indices referred to herein were measured using an Abbe refractometer at 589 nm and/or a Metricon Model 2010 prism coupler at 633 nm, 830 nm, and 1550 nm, following the guideline of ASTM Designation #D 542-95.

Generally, optical waveguides and even buried channel optical waveguides are composed of a core layer having a first index of refraction and a cladding layer having a second index of refraction, wherein the core layer is at least partially encompassed by the cladding layer. In another embodiment, the core layer is completely encompassed by the cladding layer (i.e., a buried channel structure or three-layer optical waveguide). It is the core which transmits

light and the cladding layer which confines light. In the situation where the optical waveguide is a two layer structure, the core layer is partially bound by a layer of air.

5 In view of the above, formulations for each of the core and cladding (or clad) layers will be discussed below. However, in the general sense the methods disclosed below will work with any suitable polymer or polymers so long as the resulting core and cladding (or clad) layers formed therefrom meet the necessary performance criteria for the application in which the waveguide will be utilized. Numerous waveguide performance criteria exist, Table 1 summarizes the general
10 minimum performance criteria which are applicable to all waveguides irrespective of the waveguide application. It should be noted though, that the present invention is not limited thereto. Rather, based on the polymer or polymers utilized, other performance criteria are obtainable.

TABLE I

Performance Criteria	Minimum Requirement	Comparative Performance of a Waveguide Using the Core Composition of Example CL5 and the Cladding Composition of Example CO1
Refractive Index at 830 nm Δn (core-clad):	at least about 0.00075 (which corresponds to about 0.05% where the clad refractive index is approximately 1.5)	about 0.03 (about 2.0% where the clad refractive index is approximately 1.5)
Δn Consistent Over a Broad Temp. Range:	about 0 to about 40 °C	0 to 175 °C
Intrinsic Optical Loss:	less than about 1 dB/cm	less than about 0.1 dB/cm (at 515 to 870 nm)
Transmission Loss of Waveguide:	less than about 1 dB/cm	about 0.14 dB/cm
Birefringence, both In-Plane/Out-Of-Plane (Δn):	less than about 10^{-2} /less than about 10^{-2}	less than about 10^{-5} /less than about 10^{-3}
Oxidative Stability is 2000 hours at 125 °C in air	at least 500 hours at 125 °C	at least about 2200 hours at 125 °C
Solder Reflow Compatible Due to a Minimum Glass Transition Temp. (T_g):	T_g is at least 150 °C	T_g is at least 250 °C
Low Moisture Absorption:	less than about 3%	less than about 0.3%
Mechanically Robust Due to a Minimum Elongation:	at least about 5%	at least about 10%

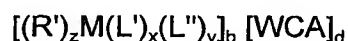
In one embodiment, waveguides can be formed via the methods discussed below by using a variety of polymer compounds, such compounds include, but are not limited to, polyacrylates (such as deuterated polyfluoromethacrylate), polyimides (such as cross-linked polyimides or fluorinated polyimides), benzocyclobutene or fluorinated benzocyclobutene.

In another embodiment, the waveguides of the present invention are formed from polymers formed from cyclic olefin monomers. In yet another embodiment, the cyclic olefin monomers used to form the waveguide polymers are norbornene-type monomers.

Formation of Cyclic Olefin Polymers:

In general, the polymerization of the cycloolefins used in one embodiment of the present invention are, in one embodiment, conducted using a Group 10 metal complex via addition polymerization to yield saturated, high glass transition temperature polymers. In another embodiment, the polymerization of the cycloolefins used in one embodiment of the present invention are conducted using a Group 10 metal complex and a weakly coordinating counteranion.

In yet another embodiment, the cycloolefins are polymerized by contacting a polymerizable polycycloolefin monomer charge with a high activity catalyst system comprising a Group 10 metal cation complex and a weakly coordinating counteranion complex of the formula:



wherein M represents a Group 10 transition metal; R' represents an anionic hydrocarbyl containing ligand; L' represents a Group 15 neutral electron donor ligand; L'' represents a labile neutral electron donor ligand; z is 0 or 1; x is 1 or 2; y is 0, 1, 2, or 3, and the sum of x, y, and z equals 4; and b and d are numbers representing the number of times the cation complex and weakly coordinating

counteranion complex (WCA), respectively, are taken to balance the electronic charge on the overall catalyst complex. The monomer charge can be neat or in solution, and is contacted with a preformed catalyst of the foregoing formula. Alternatively, the catalyst can be formed *in situ* by admixing the catalyst forming components in the monomer charge.

Catalyst System

The catalyst of the invention comprises a Group 10 metal cation complex and a weakly coordinating counteranion complex represented by Formula I below:



wherein M represents a Group 10 transition metal; R' represents an anionic hydrocarbyl ligand; L' represents a Group 15 neutral electron donor ligand; L'' represents a labile neutral electron donor ligand; x is 1 or 2; y is 0, 1, 2, or 3, wherein the sum of x, y, and z is 4; and b and d are numbers representing the number of times the cation complex and weakly coordinating counteranion complex (WCA), respectively, are taken to balance the electronic charge of the overall catalyst complex.

The weakly coordinating counteranion complex is an anion which is only weakly coordinated to the cation complex. It is sufficiently labile to be displaced by a neutral Lewis base, solvent or monomer. More specifically, the WCA anion functions as a stabilizing anion to the cation complex and does not transfer to the cation complex to form a neutral product. The WCA anion is relatively inert in that it is non-oxidative, non-reducing, and non-nucleophilic.

An anionic hydrocarbyl ligand is any hydrocarbyl ligand which when removed from the metal center M in its closed shell electron configuration, has a negative charge.

A neutral electron donor is any ligand which when removed from the metal center M in its closed shell electron configuration, has a neutral charge.

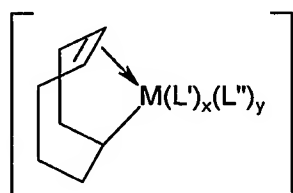
A labile neutral electron donor ligand is any ligand which is not as strongly bound to metal center M, is easily displaced therefrom, and when removed from the metal center in its closed shell electron configuration has a neutral charge.

In the cation complex above, M represents a Group 10 metal selected from nickel, palladium. In another embodiment, M represents platinum.

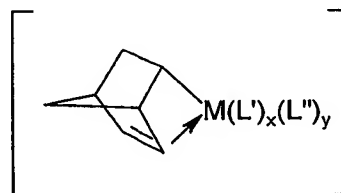
Representative anionic hydrocarbyl containing ligands defined under R' include hydrogen, linear or branched C₁-C₂₀ alkyl, C₅-C₁₀ cycloalkyl, linear or branched C₂-C₂₀ alkenyl, C₆-C₁₅ cycloalkenyl, allylic ligands or canonical forms thereof, C₆-C₃₀ aryl, C₆-C₃₀ heteroatom containing aryl, and C₇-C₃₀ aralkyl, each of the foregoing groups can be optionally substituted with hydrocarbyl and/or heteroatom substituents which, in one embodiment, are selected from linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₂-C₅ alkenyl and haloalkenyl, halogen, sulfur, oxygen, nitrogen, phosphorus, and phenyl optionally substituted with linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, and halogen, R' also represents anionic hydrocarbyl containing ligands of the formula R"¹C(O)O, R"¹OC(O)CHC(O)R", R"¹C(O)S, R"¹C(S)O, R"¹C(S)S, R"¹O, R"¹₂N, wherein R" is the same as R' defined immediately above.

The foregoing cycloalkyl, and cycloalkenyl ligands can be monocyclic or multicyclic. The aryl ligands can be a single ring (e.g., phenyl) or a fused ring system (e.g., naphthyl). In addition, any of the cycloalkyl, cycloalkenyl and aryl groups can be taken together to form a fused ring system. Each of the monocyclic, multicyclic and aryl ring systems described above optionally can be monosubstituted or multisubstituted with a substituent independently selected from hydrogen, linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, halogen selected from chlorine, fluorine, iodine and bromine, C₅-C₁₀ cycloalkyl, C₆-C₁₅ cycloalkenyl, and C₆-C₃₀ aryl. An example of a multicycloalkyl moiety is a norbornyl ligand. An example of a multicycloalkenyl moiety is a norbornenyl ligand. Examples of aryl ligand groups include phenyl and naphthyl. For purposes of illustration Structure I below

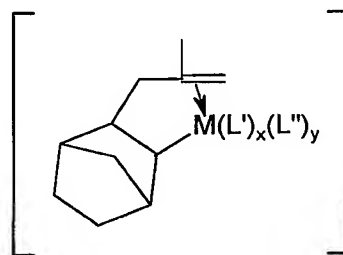
represents a cationic complex wherein R' is a cycloalkenyl ligand derived from 1,5-cyclooctadiene. Structures II and III illustrate cationic complexes wherein R' represents multicycloalkyl and multicycloalkenyl ligands, respectively. In Structure III the norbornenyl ligand is substituted with an alkenyl group.



Structure I



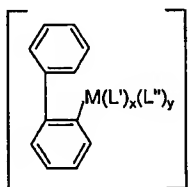
Structure II



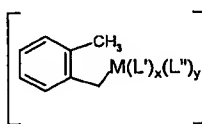
Structure III

wherein M, L', L'', x and y are as previously defined.

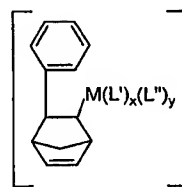
Additional examples of cationic complexes where R' represents a ring system is illustrated in Structures IV to IVc below.



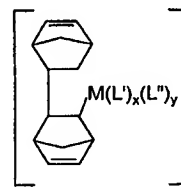
Structure IV



Structure IVa



Structure IVb

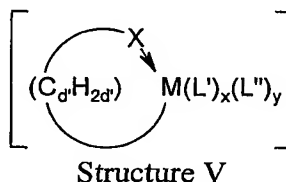


Structure IVc

wherein M, L', L'', x and y are as previously defined.

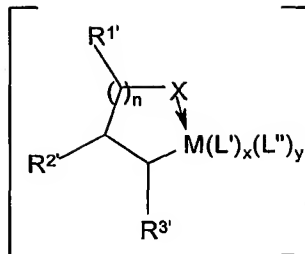
In another embodiment of the invention R' represents a hydrocarbyl ligand containing a terminal group that coordinates to the Group 10 metal. The terminal coordination group containing hydrocarbyl ligand are represented by the formula $-C_{d'}H_{2d'}X\rightarrow$, wherein d' represents the number of carbon atoms in the hydrocarbyl backbone and is an integer from 3 to 10, and $X\rightarrow$ represents an alkenyl or heteroatom containing moiety that coordinates to the Group 10 metal center. The ligand together with the Group 10 metal forms a metallacycle or heteroatom containing metallacycle. Any of the hydrogen atoms on the hydrocarbyl backbone in the formulae above can be independently replaced by a substituent selected from R^1 , R^2 , and R^3 which are defined below.

A cation complex of the terminal coordination group containing hydrocarbyl metallacycle embodiment is represented by Structure V shown below:



wherein M, L' , L'' , d' , x and y are as previously defined, and X represents a radical selected from the group $-\text{CHR}^4=\text{CHR}^4$, $-\text{OR}^4$, $-\text{SR}^4$, $-\text{N}(\text{R}^4)_2$, $-\text{N}=\text{NR}^4$, $-\text{P}(\text{R}^4)_2$, $-\text{C}(\text{O})\text{R}^4$, $-\text{C}(\text{R}^4)=\text{NR}^4$, $-\text{C}(\text{O})\text{OR}^4$, $-\text{OC}(\text{O})\text{OR}^4$, $-\text{OC}(\text{O})\text{R}^4$, and R^4 represents hydrogen, halogen, linear or branched C_1 - C_5 alkyl, linear or branched C_1 - C_5 haloalkyl, C_5 - C_{10} cycloalkyl, linear or branched C_2 - C_5 alkenyl, linear or branched C_2 - C_5 haloalkenyl, substituted and unsubstituted C_6 - C_{18} aryl, and substituted and unsubstituted C_7 - C_{24} aralkyl.

The substituted terminal group containing hydrocarbyl metallacycles can be represented by structure Va, below.

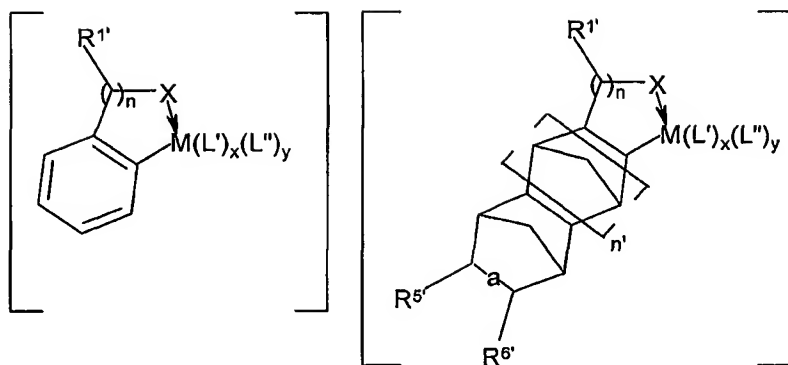


Structure Va

wherein M, L', L'', X, x and y are as previously defined, n represents an integer from 0 to 8 and R^{1'}, R^{2'}, and R^{3'} independently represent hydrogen, linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₂-C₅ alkenyl, linear or branched C₂-C₅ haloalkenyl, substituted and unsubstituted C₆-C₃₀ aryl, substituted and unsubstituted C₇-C₃₀ aralkyl, and halogen. Any of R^{1'}, R^{2'}, and R^{3'} can be taken together along with the carbon atoms to which they are attached can form a substituted or unsubstituted aliphatic C₅-C₂₀ monocyclic or polycyclic ring system, a substituted or unsubstituted C₆-C₁₀ aromatic ring system, a substituted and unsubstituted C₁₀-C₂₀ fused aromatic ring system, and combinations thereof. When substituted, the rings described above can contain monosubstitution or multisubstitution where the substituents are independently selected from hydrogen, linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, and halogen selected from chlorine, fluorine, iodine and bromine. In Structure Va above it should be noted that when n is 0, X is bonded to the carbon atom that contains the R^{2'} substituent.

Representative terminal group containing hydrocarbyl metallacycle cation complexes wherein the substituents are taken together to represent aromatic and aliphatic ring systems are illustrated below under Structures Vb and Vc.

5

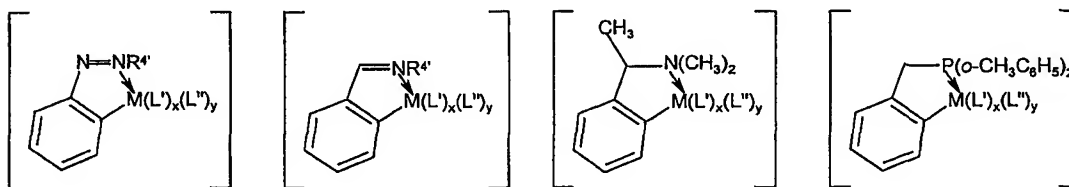


Structure Vb

Structure Vc

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Additional examples of terminal group containing hydrocarbonyl metallacycle cation complexes wherein any of R^{1'} to R^{3'} can be taken together to form aromatic ring systems are set forth in Structures Vd to Vg below.



Structure Vd

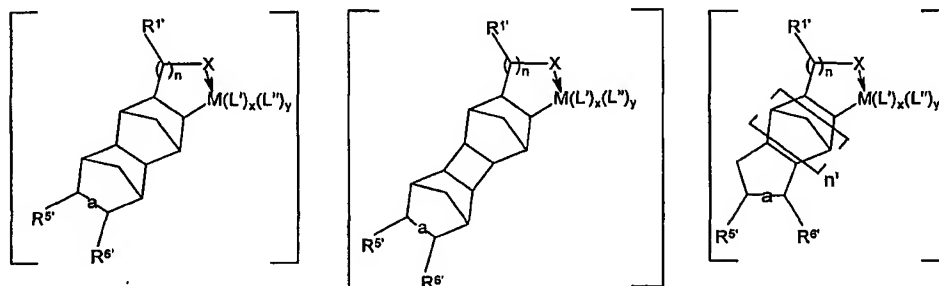
Structure Ve

Structure Vf

Structure Vg

Illustrative examples of cation complexes containing polycyclic aliphatic ring systems are set forth under structures Vh, Vi, and Vj below:

15



Structure Vh

Structure Vi

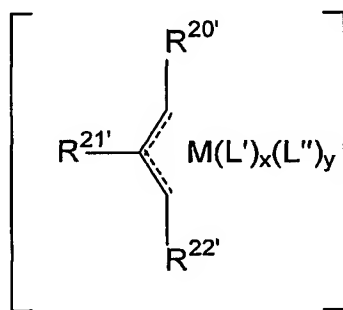
Structure Vj

20

In Structures V through Vj above, n' is an integer from 0 to 5; and X, M, L', L'', n, x, y, $R^{1'}$ and $R^{4'}$, are as previously defined, and "a" represents a single or double bond, $R^{5'}$ and $R^{6'}$ independently represent hydrogen, and linear or branched C_1 - C_{10} alkyl, $R^{5'}$ and $R^{6'}$ together with the carbon atoms to which they are attached can form a saturated and unsaturated cyclic group containing 5 to 15 carbon atoms.

Examples of heteroatom containing aryl ligands under R' are pyridinyl and quinolinyl ligands.

The allyl ligand in the cationic complex can be represented by the following structure:

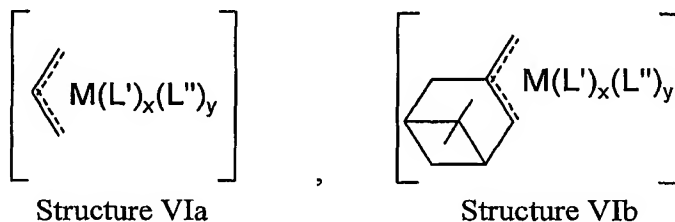


Structure VI

wherein $R^{20'}$, $R^{21'}$, and $R^{22'}$ each independently represent hydrogen, halogen, linear or branched C_1 - C_5 alkyl, C_5 - C_{10} cycloalkyl, linear or branched C_1 - C_5 alkenyl, C_6 - C_{30} aryl, C_7 - C_{30} aralkyl, each optionally substituted with a substituent selected from linear or branched C_1 - C_5 alkyl, linear or branched C_1 - C_5 haloalkyl, halogen, and phenyl which can optionally be substituted with linear or branched C_1 - C_5 alkyl, linear or branched C_1 - C_5 haloalkyl, and halogen. Any two of $R^{20'}$, $R^{21'}$, and $R^{22'}$ can be linked together with the carbon atoms to which they are attached to form a cyclic or multicyclic ring, each optionally substituted with linear or branched C_1 - C_5 alkyl, linear or branched C_1 - C_5 haloalkyl, and halogen. Examples

of allylic ligands suitable in the cationic complexes of the invention include but are not limited to allyl, 2-chloroallyl, crotyl, 1,1-dimethyl allyl, 2-methylallyl, 1-phenylallyl, 2-phenylallyl, and β -pinenyl.

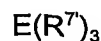
Representative cationic complexes containing an allylic ligand are shown below.



In Structures VI, VIa, and VIb M, L', L'', x and y are as previously defined.

Additional examples of allyl ligands are found in R. G. Guy and B. L. Shaw, *Advances in Inorganic Chemistry and Radiochemistry*, Vol. 4, Academic Press Inc., New York, 1962; J. Birmingham, E. de Boer, M. L. H. Green, R.B. King, R. Köster, P.L.I. Nagy, G.N. Schrauzer, *Advances in Organometallic Chemistry*, Vol. 2, Academic Press Inc., New York, 1964; W. T. Dent, R. Long and A. J. Wilkinson, *J. Chem. Soc.*, (1964) 1585; and H.C. Volger, *Rec. Trav. Chim. Pay Bas*, 88 (1969) 225; which are all hereby incorporated by reference.

Representative neutral electron donor ligands under L' include amines, pyridines organophosphorus containing compounds and arsines and stibines, of the formula:



wherein E is arsenic or antimony, and R⁷ is independently selected from hydrogen, linear or branched C₁-C₁₀ alkyl, C₅-C₁₀ cycloalkyl, linear or branched C₁-C₁₀ alkoxy, allyl, linear or branched C₂-C₁₀ alkenyl, C₆-C₁₂ aryl, C₆-C₁₂ aryloxy, C₆-C₁₂ arylsulfides (e.g., PhS), C₇-C₁₈ aralkyl, cyclic ethers and thioethers,

tri(linear or branched C₁-C₁₀ alkyl)silyl, tri(C₆-C₁₂ aryl)silyl, tri(linear or branched C₁-C₁₀ alkoxy)silyl, triaryloxysilyl, tri(linear or branched C₁-C₁₀ alkyl)siloxy, and tri(C₆-C₁₂ aryl)siloxy, each of the foregoing substituents can be optionally substituted with linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, C₁-C₅ alkoxy, halogen, and combinations thereof. Representative alkyl groups include but are not limited to methyl, ethyl, propyl, isopropyl, n-butyl, isobutyl, sec-butyl, tert-butyl, pentyl, neopentyl, hexyl, heptyl, octyl, nonyl, decyl, and dodecyl. Representative cycloalkyl groups include but are not limited to cyclopentyl and cyclohexyl. Representative alkoxy groups include but are not limited to methoxy, ethoxy, and isopropoxy. Representative cyclic ether and cyclic thioether groups include but are not limited to furyl and thienyl, respectively. Representative aryl groups include but are not limited to phenyl, o-tolyl, and naphthyl. Representative aralkyl groups include but are not limited to benzyl, and phenylethyl (i.e., -CH₂CH₂PH). Representative silyl groups include but are not limited to triphenylsilyl, trimethylsilyl, and triethylsilyl. As in the general definition above each of the foregoing groups can be optionally substituted with linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, and halogen.

Representative pyridines include lutidine (including 2,3-; 2,4-; 2,5-; 2,6-; 3,4-; and 3,5-substituted), picoline (including 2-,3-, or 4-substituted), 2,6-di-*t*-butylpyridine, and 2,4-di-*t*-butylpyridine.

Representative arsines include triphenylarsine, triethylarsine, and triethoxysilylarsine.

Representative stibines include triphenylstibine and trithiophenylstibine.

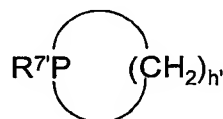
Suitable amine ligands can be selected from amines of the formula N(R⁸)₃, wherein R⁸ independently represents hydrogen, linear or branched C₁-C₂₀ alkyl, linear or branched C₁-C₂₀ haloalkyl, substituted and unsubstituted C₃-C₂₀ cycloalkyl, substituted and unsubstituted C₆-C₁₈ aryl, and substituted and unsubstituted C₇-C₁₈ aralkyl. When substituted, the cycloalkyl, aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₁₂ alkyl, linear or

branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, C₆-C₁₂ aryl, and halogen selected from chlorine, bromine, and fluorine. Representative amines include but are not limited to ethylamine, triethylamine, diisopropylamine, tributylamine, N,N-dimethylaniline, N,N-dimethyl-4-*t*-butylaniline, N,N-dimethyl-4-*t*-octylaniline, and N,N-dimethyl-4-hexadecylaniline.

The organophosphorus containing ligands include phosphines, phosphites, phosphonites, phosphinites and phosphorus containing compounds of the formula:

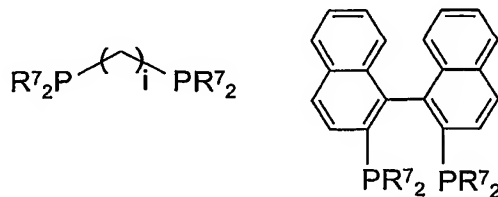


wherein X' is oxygen, nitrogen, or silicon, R⁷ is as defined above and each R⁷ substituent is independent of the other, g is 0, 1, 2, or 3, and h is 1, 2, or 3, with the proviso that when X' is a silicon atom, h is 3, when X' is an oxygen atom h is 1, and when X' is a nitrogen atom, h is 2. When g is 0 and X' is oxygen, any two or 3 of R⁷ can be taken together with the oxygen atoms to which they are attached to form a cyclic moiety. When g is 3 any two of R⁷ can be taken together with the phosphorus atom to which they are attached to represent a phosphacycle of the formula:



wherein R⁷ is as previously defined and h' is an integer from 4 to 11.

The organophosphorus compounds can also include bidentate phosphine ligands of the formulae:



wherein R⁷ is as previously defined and i is 0, 1, 2, or 3 are also contemplated herein.

Representative phosphine ligands include, but are not limited to

trimethylphosphine, triethylphosphine, tri-*n*-propylphosphine,

5 triisopropylphosphine, tri-*n*-butylphosphine, tri-*sec*-butylphosphine,

tri-*i*-butylphosphine, tri-*t*-butylphosphine, tricyclopentylphosphine,

triallylphosphine, tricyclohexylphosphine, triphenylphosphine,

trinaphthylphosphine, tri-*p*-tolylphosphine, tri-*o*-tolylphosphine,

tri-*m*-tolylphosphine, tribenzylphosphine, tri(*p*-trifluoromethylphenyl)phosphine,

10 tris(trifluoromethyl)phosphine, tri(*p*-fluorophenyl)phosphine, tri(*p*-

trifluoromethylphenyl)phosphine, allyldiphenylphosphine,

benzyldiphenylphosphine, bis(2-furyl)phosphine, bis(4-

methoxyphenyl)phenylphosphine, bis(4-methylphenyl)phosphine,

bis(3,5-bis(trifluoromethyl)phenyl)phosphine, *t*-butylbis(trimethylsilyl)phosphine, *t*-

15 butyldiphenylphosphine, cyclohexyldiphenylphosphine, diallylphenylphosphine,

dibenzylphosphine, dibutylphenylphosphine, dibutylphosphine,

di-*t*-butylphosphine, dicyclohexylphosphine, diethylphenylphosphine, di-*i*-

butylphosphine, dimethylphenylphosphine, dimethyl(trimethylsilyl)phosphine,

diphenylphosphine, diphenylpropylphosphine, diphenyl(*p*-tolyl)phosphine,

20 diphenyl(trimethylsilyl)phosphine, diphenylvinylphosphine,

divinylphenylphosphine, ethyldiphenylphosphine,

(2-methoxyphenyl)methylphenylphosphine, tri-*n*-octylphosphine,

tris(3,5-bis(trifluoromethyl)phenyl)phosphine, tris(3-chlorophenyl)phosphine,

tris(4-chlorophenyl)phosphine, tris(2,6-dimethoxyphenyl)phosphine, tris(3-

25 fluorophenyl)phosphine, tris(2-furyl)phosphine, tris(2-methoxyphenyl)phosphine,

tris(3-methoxyphenyl)phosphine, tris(4-methoxyphenyl)phosphine,

tris(3-methoxypropyl)phosphine, tris(2-thienyl)phosphine,

tris(2,4,6-trimethylphenyl)phosphine, tris(trimethylsilyl)phosphine,

isopropyldiphenylphosphine, dicyclohexylphenylphosphine,

(+)-neomenthyldiphenylphosphine, tribenzylphosphine, diphenyl(2-methoxyphenyl)phosphine, diphenyl(pentafluorophenyl)phosphine, bis(pentafluorophenyl)phenylphosphine, and tris(pentafluorophenyl)phosphine.

Exemplary bidentate phosphine ligands include but are not limited to (R)-
 5 (+)-2,2'-Bis(diphenylphosphino)-1,1'-binaphthyl;
 bis(dicyclohexylphosphino)methane; bis(dicyclohexylphosphino)ethane;
 bis(diphenylphosphino)methane; bis(diphenylphosphino)ethane.

The phosphine ligands can also be selected from phosphine compounds that are water soluble thereby imparting the resulting catalysts with solubility in
 10 aqueous media. Selected phosphines of this type include but are not limited to carboxylic substituted phosphines such as 4-(diphenylphosphine)benzoic acid, and 2-(diphenylphosphine)benzoic acid, sodium
 2-(dicyclohexylphosphino)ethanesulfonate,
 4,4'-(phenylphosphinidene)bis(benzene sulfonic acid) dipotassium salt, 3,3',3"-
 15 phosphinidynetris(benzene sulfonic acid) trisodium salt,
 4-(dicyclohexylphosphino)-1,1-dimethylpiperidinium chloride,
 4-(dicyclohexylphosphino)-1,1-dimethylpiperidinium iodide, quaternary amine-
 functionalized salts of phosphines such as 2-(dicyclohexylphosphino)-N,N,N-
 trimethylethanaminium chloride,
 20 2,2'-(cyclohexylphosphinidene)bis[N,N,N-trimethylethanaminium dichloride,
 2,2'-(cyclohexylphosphinidene)bis(N,N,N-trimethylethanaminium) diiodide, and
 2-(dicyclohexylphosphino)-N,N,N-trimethylethanaminium iodide.

Examples of phosphite ligands include but are not limited to
 trimethylphosphite, diethylphenylphosphite, triethylphosphite,
 25 tris(2,4-di-*t*-butylphenyl)phosphite, tri-*n*-propylphosphite, triisopropylphosphite, tri-
n-butylphosphite, tri-*sec*-butylphosphite, triisobutylphosphite, tri-*t*-butylphosphite,
 dicyclohexylphosphite, tricyclohexylphosphite, triphenylphosphite,
 tri-*p*-tolylphosphite, tris(*p*-trifluoromethylphenyl)phosphite,
 benzyldiethylphosphite, and tribenzylphosphite.

Examples of phosphinite ligands include but are not limited to methyl diphenylphosphinite, ethyl diphenylphosphinite, isopropyl diphenylphosphinite, and phenyl diphenylphosphinite.

Examples of phosphonite ligands include but are not limited to diphenyl phenylphosphonite, dimethyl phenylphosphonite, diethyl methylphosphonite, diisopropyl phenylphosphonite, and diethyl phenylphosphonite.

Representative labile neutral electron donor ligands (L") are reaction diluent, reaction monomers, DMF, DMSO, dienes including C₄ to C₁₀ aliphatic and C₄ to C₁₀ cycloaliphatic dienes representative dienes include butadiene, 1,6-hexadiene, and cyclooctadiene (COD), water, chlorinated alkanes, alcohols, ethers, ketones, nitriles, arenes, phosphine oxides, organic carbonates and esters.

Representative chlorinated alkanes include but are not limited to dichloromethane, 1,2-dichloroethane, and carbon tetrachloride.

Suitable alcohol ligands can be selected from alcohols of the formula R⁹OH, wherein R⁹ represents linear or branched C₁-C₂₀ alkyl, linear or branched C₁-C₂₀ haloalkyl, substituted and unsubstituted C₃-C₂₀ cycloalkyl, substituted and unsubstituted C₆-C₁₈ aryl, and substituted and unsubstituted C₆-C₁₈ aralkyl. When substituted, the cycloalkyl, aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₁₂ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, C₆-C₁₂ aryl, and halogen selected from chlorine, bromine, and fluorine. Representative alcohols include but are not limited to methanol, ethanol, n-propanol, isopropanol, butanol, hexanol, *t*-butanol, neopentanol, phenol, 2,6-di-*i*-propylphenol, 4-*t*-octylphenol, 5-norbornene-2-methanol, and dodecanol.

Suitable ether ligands and thioether ligands can be selected from ethers and thioethers of the formulae (R^{10'}-O-R^{10'}) and (R^{10'}-S-R^{10'}), respectively, wherein R^{10'} independently represents linear or branched C₁-C₁₀ alkyl radicals, linear or branched C₁-C₂₀ haloalkyl, substituted and unsubstituted C₃-C₂₀ cycloalkyl, linear

or branched C₁-C₂₀ alkoxy substituted and unsubstituted C₆-C₁₈ aryl, and substituted and unsubstituted C₆-C₁₈ aralkyl. When substituted, the cycloalkyl, aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₁₂ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, C₆-C₁₂ aryl, and halogen selected from chlorine, bromine, and fluorine. taken together along with the oxygen or sulfur atom to which they are attached to form a cyclic ether or cyclic thioether. Representative ethers include but are not limited to dimethyl ether, dibutyl ether, methyl-*t*-butyl ether, di-*i*-propyl ether, diethyl ether, dioctyl ether, 1,4-dimethoxyethane, THF, 1,4-dioxane and tetrahydrothiophene.

Suitable ketone ligands are represented by ketones of the formula R^{11'}C(O)R^{11'} wherein R^{11'} independently represents hydrogen, linear or branched C₁-C₂₀ alkyl, linear or branched C₁-C₂₀ haloalkyl, substituted and unsubstituted C₃-C₂₀ cycloalkyl, substituted and unsubstituted C₆-C₁₈ aryl, and substituted and unsubstituted C₆-C₁₈ aralkyl. When substituted, the cycloalkyl, aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₁₂ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, C₆-C₁₂ aryl, and halogen selected from chlorine, bromine, and fluorine. Representative ketones include but are not limited to acetone, methyl ethyl ketone, cyclohexanone, and benzophenone.

The nitrile ligands can be represented by the formula R^{12'}CN, wherein R^{12'} represents hydrogen, linear or branched C₁-C₂₀ alkyl, linear or branched C₁-C₂₀ haloalkyl, substituted and unsubstituted C₃-C₂₀ cycloalkyl, substituted and unsubstituted C₆-C₁₈ aryl, and substituted and unsubstituted C₆-C₁₈ aralkyl. When substituted, the cycloalkyl, aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₁₂ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, C₆-C₁₂ aryl, and halogen selected from chlorine, bromine, and fluorine. Representative nitriles include but are not limited to

acetonitrile, propionitrile, benzonitrile, benzyl cyanide, and 5-norbornene-2-carbonitrile.

The arene ligands can be selected from substituted and unsubstituted C₆-C₁₂ arenes containing monosubstitution or multisubstitution, wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₁₂ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, C₆-C₁₂ aryl, and halogen selected from chlorine, bromine, and fluorine. Representative arenes include but are not limited to toluene, benzene, *o*-, *m*-, and *p*-xylenes, mesitylene, fluorobenzene, *o*-difluorobenzene, *p*-difluorobenzene, chlorobenzene, pentafluorobenzene, *o*-dichlorobenzene, and hexafluorobenzene.

Suitable trialkyl and triaryl phosphine oxide ligands can be represented by phosphine oxides of the formula P(O)(R^{13'})₃, wherein R^{13'} independently represents linear or branched C₁-C₂₀ alkyl, linear or branched C₁-C₂₀ haloalkyl, substituted and unsubstituted C₃-C₂₀ cycloalkyl, linear or branched C₁-C₂₀ alkoxy, linear or branched C₁-C₂₀ haloalkoxy, substituted and unsubstituted C₆-C₁₈ aryl, and substituted and unsubstituted C₆-C₁₈ aralkyl. When substituted, the cycloalkyl, aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₁₂ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, C₆-C₁₂ aryl, and halogen selected from chlorine, bromine, and fluorine. Representative phosphine oxides include but are not limited to triphenylphosphine oxide, tributylphosphine oxide, trioctylphosphine oxide, tributylphosphate, and tris(2-ethylhexyl)phosphate.

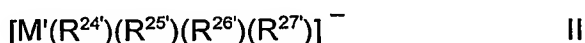
Representative carbonates include but are not limited to ethylene carbonate and propylene carbonate.

Representative esters include but are not limited to ethyl acetate and *i*-amyl acetate.

WCA Description

The weakly coordinating counteranion complex, [WCA], of Formula I can be selected from borates and aluminates, boratobenzene anions, carborane and halocarborane anions.

5 The borate and aluminate weakly coordinating counteranions are represented by Formulae II and III below:



wherein in Formula II M' is boron or aluminum and R^{24'}, R^{25'}, R^{26'}, and R^{27'} independently represent fluorine, linear or branched C₁-C₁₀ alkyl, linear or branched C₁-C₁₀ alkoxy, linear or branched C₃-C₅ haloalkenyl, linear or branched C₃-C₁₂ trialkylsiloxy, C₁₈-C₃₆ triarylsiloxy, substituted and unsubstituted C₆-C₃₀ aryl, and substituted and unsubstituted C₆-C₃₀ aryloxy groups wherein R^{24'} to R^{27'} can not all simultaneously represent alkoxy or aryloxy groups. When substituted the aryl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, linear or branched C₁-C₅ haloalkoxy, linear or branched C₁-C₁₂ trialkylsilyl, C₆-C₁₈ triarylsilyl, and halogen selected from chlorine, bromine, and fluorine. In another embodiment, the halogen is fluorine.

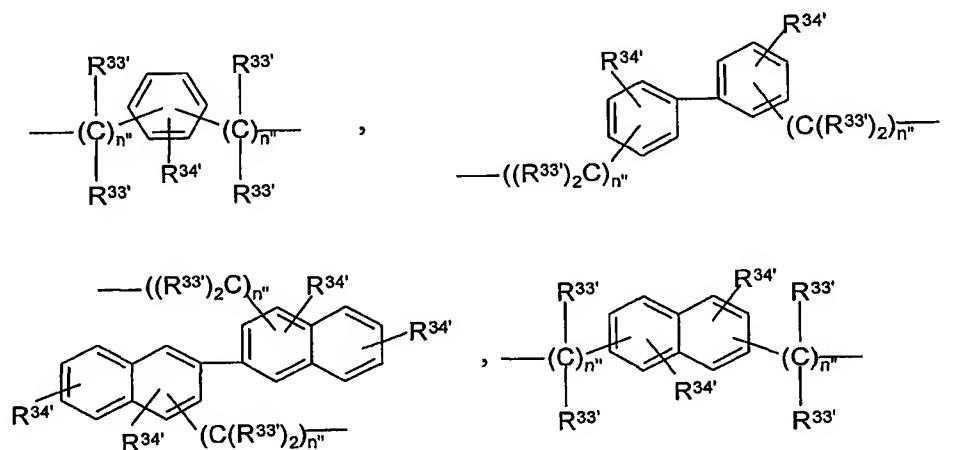
Representative borate anions under Formula II include but are not limited to tetrakis(pentafluorophenyl)borate, tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, tetrakis(2-fluorophenyl)borate, tetrakis(3-fluorophenyl)borate, tetrakis(4-fluorophenyl)borate, tetrakis(3,5-difluorophenyl)borate, tetrakis(2,3,4,5-tetrafluorophenyl)borate, tetrakis(3,4,5,6-tetrafluorophenyl)borate, tetrakis(3,4,5-trifluorophenyl)borate, methyltris(perfluorophenyl)borate, ethyltris(perfluorophenyl)borate,

phenyltris(perfluorophenyl)borate, tetrakis(1,2,2-trifluoroethylenyl)borate, tetrakis(4-tri-*i*-propylsilyltetrafluorophenyl)borate, tetrakis(4-dimethyl-*tert*-butylsilyltetrafluorophenyl)borate, (triphenylsiloxy)tris(pentafluorophenyl)borate, (octyloxy)tris(pentafluorophenyl)borate, tetrakis[3,5-bis[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]phenyl]borate, tetrakis[3-[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate, and tetrakis[3-[2,2,2-trifluoro-1-(2,2,2-trifluoroethoxy)-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate.

Representative aluminate anions under Formula II include but are not limited to tetrakis(pentafluorophenyl)aluminate, tris(perfluorobiphenyl)fluoroaluminate, (octyloxy)tris(pentafluorophenyl)aluminate, tetrakis(3,5-bis(trifluoromethyl)phenyl)aluminate, and methyltris(pentafluorophenyl)aluminate.

In Formula III M' is boron or aluminum, R^{28'}, R^{29'}, R^{30'}, and R^{31'} independently represent linear or branched C₁-C₁₀ alkyl, linear or branched C₁-C₁₀ haloalkyl, C₂-C₁₀ haloalkenyl, substituted and unsubstituted C₆-C₃₀ aryl, and substituted and unsubstituted C₇-C₃₀ aralkyl groups, subject to the proviso that at least three of R^{28'} to R^{31'} must contain a halogen containing substituent. When substituted the aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently selected from linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, linear or branched C₁-C₁₀ haloalkoxy, and halogen selected from chlorine, bromine, and fluorine. In another embodiment, the halogen is fluorine. The groups OR^{28'} and OR^{29'} can be taken together to form a chelating substituent represented by -O-R^{32'}-O-, wherein the oxygen atoms are bonded to M' and R^{32'} is a divalent radical selected from substituted and unsubstituted C₆-C₃₀ aryl and substituted and unsubstituted C₇-C₃₀ aralkyl. In one embodiment, the oxygen atoms are bonded, either directly or through an alkyl group, to the aromatic ring in the ortho or meta position. When substituted the aryl and aralkyl groups can be monosubstituted or multisubstituted, wherein the substituents are independently

selected from linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, linear or branched C₁-C₁₀ haloalkoxy, and halogen selected from chlorine, bromine, and fluorine. In another embodiment, the halogen is fluorine. Representative structures of divalent R^{32'} radicals are illustrated below:

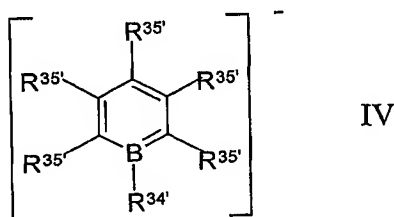


wherein R^{33'} independently represents hydrogen, linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, and halogen selected from chlorine, bromine, and fluorine (in another embodiment, the halogen is fluorine); R^{34'} can be a monosubstituent or taken up to four times about each aromatic ring depending on the available valence on each ring carbon atom and independently represents hydrogen, linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, linear or branched C₁-C₁₀ haloalkoxy, and halogen selected from chlorine, bromine, and fluorine (in one embodiment, the halogen is fluorine); and n'' independently represents an integer from 0 to 6. It should be recognized that when n'' is 0 the oxygen atom in the formula -O-R^{32'}-O- is bonded directly to a carbon atom in the aromatic ring represented by R^{32'}. In the above divalent structural formulae the oxygen atom(s), i.e., when n'' is 0, and the methylene or substituted methylene group(s), -(C(R^{33'}))₂n'', are, in one embodiment, located on the aromatic ring in the ortho or meta positions. Representative chelating groups of the formula -O-R^{32'}-O- include but are not

limited to are 2,3,4,5-tetrafluorobenzenediolate ($-\text{OC}_6\text{F}_4\text{O}-$), 2,3,4,5-tetrachlorobenzenediolate ($-\text{OC}_6\text{Cl}_4\text{O}-$), and 2,3,4,5-tetrabromobenzenediolate ($-\text{OC}_6\text{Br}_4\text{O}-$), and bis(1,1'-bitetrafluorophenyl-2,2'-diolate).

Representative borate and aluminate anions under Formula III include but are not limited to $[\text{B}(\text{OC}(\text{CF}_3)_3)_4]^-$, $[\text{B}(\text{OC}(\text{CF}_3)_2(\text{CH}_3))_4]^-$, $[\text{B}(\text{OC}(\text{CF}_3)_2\text{H})_4]^-$, $[\text{B}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{Ph})_4]^-$, $[\text{B}(\text{OCH}_2(\text{CF}_3)_2)_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{CH}_3)_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_3)_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{H})_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4-4-i\text{-Pr})_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4-4-t\text{-butyl})_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4-4-\text{SiMe}_3)_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4-4-\text{Si}-i\text{-Pr}_3)_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2-2,6-(\text{CF}_3)_2-4-\text{Si}-i\text{-Pr}_3)_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_3-3,5-(\text{CF}_3)_2)_4]^-$, $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2-2,4,6-(\text{CF}_3)_3)_4]^-$, and $[\text{Al}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{F}_5)_4]^-$.

The boratobenzene anions useful as the weakly coordinating counteranion can be represented by Formula IV below:



wherein $\text{R}^{34'}$ is selected from fluorine, fluorinated hydrocarbyl, perfluorocarbyl, and fluorinated and perfluorinated ethers. As used here and throughout the specification, the term halohydrocarbyl means that at least one hydrogen atom on the hydrocarbyl radical, e.g., alkyl, alkenyl, alkynyl, cycloalkyl, aryl, and aralkyl groups, is replaced with a halogen atom selected from chlorine, bromine, iodine, and fluorine (e.g., haloalkyl, haloalkenyl, haloalkynyl, halocycloalkyl, haloaryl, and haloaralkyl). The term fluorohydrocarbyl means that at least one hydrogen atom on the hydrocarbyl radical is replaced by fluorine. The degree of halogenation can range from at least one hydrogen atom being replaced by a halogen atom (e.g., a monofluoromethyl group) to full halogenation (perhalogenation) wherein all hydrogen atoms on the hydrocarbyl group have

been replaced by a halogen atom (e.g., perhalocarbyl such as trifluoromethyl (perfluoromethyl)). The fluorinated hydrocarbyl and perfluorocarbyl radicals contain, in one embodiment, 1 to 24 carbon atoms. In another embodiment, the fluorinated hydrocarbyl and perfluorocarbyl radicals contain 1 to 12 carbon atoms. In yet another embodiment, fluorinated hydrocarbyl and perfluorocarbyl radicals contain 6 carbon atoms and can be linear or branched, cyclic, or aromatic. The fluorinated hydrocarbyl and perfluorocarbyl radicals include but are not limited to fluorinated and perfluorinated linear or branched C₁-C₂₄ alkyl, fluorinated and perfluorinated C₃-C₂₄ cycloalkyl, fluorinated and perfluorinated C₂-C₂₄ alkenyl, fluorinated and perfluorinated C₃-C₂₄ cycloalkenyl, fluorinated and perfluorinated C₆-C₂₄ aryl, and fluorinated and perfluorinated C₇-C₂₄ aralkyl. The fluorinated and perfluorocarbyl ether substituents are represented by the formulae -(CH₂)_mOR^{36'}, or -(CF₂)_mOR^{36'} respectively, wherein R^{36'} is a fluorinated or perfluorocarbyl group as defined above, m is an integer of 0 to 5. It is to be noted that when m is 0 the oxygen atom in the ether moiety is directly bonded attached to the boron atom in the boratobenzene ring.

In one embodiment, R^{34'} radicals include those that are electron withdrawing in nature such as, for example, fluorinated and perfluorinated hydrocarbyl radicals selected from trifluoromethyl, perfluoroethyl, perfluoropropyl, perfluoroisopropyl, pentafluorophenyl and bis(3,5-trifluoromethyl)phenyl.

R^{35'} independently represents hydrogen, halogen, perfluorocarbyl, and silylperfluorocarbyl radicals, wherein the perfluorocarbyl and silylperfluorocarbyl are as defined previously. In one embodiment, the halogen groups are selected from chlorine, fluorine. In another embodiment, the halogen is fluorine. When R^{35'} is halogen, perfluorocarbyl, and/or silylperfluorocarbyl, the radical(s) are, in one embodiment, ortho or para to the boron atom in the boratobenzene ring. In another embodiment, when R^{35'} is halogen, perfluorocarbyl, and/or silylperfluorocarbyl, the radical(s) are para to the boron atom in the boratobenzene ring.

Representative boratobenzene anions include but are not limited to [1,4-dihydro-4-methyl-1-(pentafluorophenyl)]-2-borate, 4-(1,1-dimethyl)-1,2-dihydro-1-(pentafluorophenyl)-2-borate, 1-fluoro-1,2-dihydro-4-(pentafluorophenyl)-2-borate, and 1-[3,5-bis(trifluoromethyl)phenyl]-1,2-dihydro-4-(pentafluorophenyl)-2-borate.

The carborane and halocarborane anions useful as the weakly coordinating counteranion include but are not limited to $\text{CB}_{11}(\text{CH}_3)_{12}^-$, $\text{CB}_{11}\text{H}_{12}^-$, $1\text{-C}_2\text{H}_5\text{CB}_{11}\text{H}_{11}^-$, $1\text{-Ph}_3\text{SiCB}_{11}\text{H}_{11}^-$, $1\text{-CF}_3\text{CB}_{11}\text{H}_{11}^-$, $12\text{-BrCB}_{11}\text{H}_{11}^-$, $12\text{-BrCB}_{11}\text{H}_{11}^-$, $7,12\text{-Br}_2\text{CB}_{11}\text{H}_{10}^-$, $12\text{-ClCB}_{11}\text{H}_{11}^-$, $7,12\text{-Cl}_2\text{CB}_{11}\text{H}_{10}^-$, $1\text{-H-CB}_{11}\text{F}_{11}^-$, $1\text{-CH}_3\text{-CB}_{11}\text{F}_{11}^-$, $1\text{-CF}_3\text{-CB}_{11}\text{F}_{11}^-$, $12\text{-CB}_{11}\text{H}_{11}\text{F}^-$, $7,12\text{-CB}_{11}\text{H}_{11}\text{F}_2^-$, $7,9,12\text{-CB}_{11}\text{H}_{11}\text{F}_3^-$, $\text{CB}_{11}\text{H}_6\text{Br}_6^-$, $6\text{-CB}_9\text{H}_9\text{F}^-$, $6,8\text{-CB}_9\text{H}_8\text{F}_2^-$, $6,7,8\text{-CB}_9\text{H}_7\text{F}_3^-$, $6,7,8,9\text{-CB}_9\text{H}_6\text{F}_4^-$, $2,6,7,8,9\text{-CB}_9\text{H}_5\text{F}_5^-$, $\text{CB}_9\text{H}_5\text{Br}_5^-$, $\text{CB}_{11}\text{H}_6\text{Cl}_6^-$, $\text{CB}_{11}\text{H}_6\text{F}_6^-$, $\text{CB}_{11}\text{H}_6\text{I}_6^-$, $\text{CB}_{11}\text{H}_6\text{Br}_6^-$, $6,7,9,10,11,12\text{-CB}_{11}\text{H}_6\text{F}_6^-$, $2,6,7,8,9,10\text{-CB}_9\text{H}_5\text{F}_5^-$, $1\text{-H-CB}_9\text{F}_9^-$, $12\text{-CB}_{11}\text{H}_{11}(\text{C}_6\text{H}_5)^-$, $1\text{-C}_6\text{F}_5\text{-CB}_{11}\text{H}_5\text{Br}_6^-$, $\text{CB}_{11}\text{Me}_{12}^-$, $\text{CB}_{11}(\text{CF}_3)_{12}^-$, $\text{Co}(\text{B}_9\text{C}_2\text{H}_{11})_2^-$, $\text{CB}_{11}(\text{CH}_3)_{12}^-$, $\text{CB}_{11}(\text{C}_4\text{H}_9)_{12}^-$, $\text{CB}_{11}(\text{C}_6\text{H}_{13})_{12}^-$, $\text{Co}(\text{C}_2\text{B}_9\text{H}_{11})_2^-$, $\text{Co}(\text{Br}_3\text{C}_2\text{B}_9\text{H}_8)_2^-$ and dodecahydro-1-carbadodecaborate.

Catalyst Preparation

The catalysts of Formula I can be prepared as a preformed single component catalyst in solvent or can be prepared *in situ* by admixing the catalyst precursor components in the desired monomer to be polymerized.

The single component catalyst of Formula I can be prepared by admixing the catalyst precursors in an appropriate solvent, allowing the reaction to proceed under appropriate temperature conditions, and isolating the catalyst product. In another embodiment, a Group 10 metal pro-catalyst is admixed with a Group 15 electron donor compound and/or a labile neutral electron donor compound, and a salt of a weakly coordinating anion in an appropriate solvent to yield the preformed catalyst complex set forth under Formula I above. In another embodiment a Group 10 metal pro-catalyst containing a Group 15 electron donor ligand is admixed with a salt of a weakly coordinating anion in an appropriate solvent to yield the preformed catalyst complex.

The catalyst preparation reactions are carried out in solvents that are inert under the reaction conditions. Examples of solvents suitable for the catalyst preparation reaction include but are not limited to alkane and cycloalkane solvents such as pentane, hexane, heptane, and cyclohexane; halogenated alkane solvents such as dichloromethane, chloroform, carbon tetrachloride, ethylchloride, 1,1-dichloroethane, 1,2-dichloroethane, 1-chloropropane, 2-chloropropane, 1-chlorobutane, 2-chlorobutane, 1-chloro-2-methylpropane, and 1-chloropentane; ethers such as THF and diethylether; aromatic solvents such as benzene, xylene, toluene, mesitylene, chlorobenzene, and *o*-dichlorobenzene; and halocarbon solvents such as Freon[®] 112; and mixtures thereof. In one embodiment, solvents include, for example, benzene, fluorobenzene, *o*-difluorobenzene, *p*-difluorobenzene, pentafluorobenzene, hexafluorobenzene, *o*-dichlorobenzene, chlorobenzene, toluene, *o*-, *m*-, and *p*-xylenes, mesitylene, cyclohexane, THF, and dichloromethane.

A suitable temperature range for carrying out the reaction is from about -80°C to about 150°C. In another embodiment, the temperature range for carrying out the reaction is from about -30°C to about 100°C. In yet another embodiment, the temperature range for carrying out the reaction is from about 0°C to about 65°C. In still yet another embodiment, the temperature range for carrying out the reaction is from about 10°C to about 40°C. Pressure is not critical but may depend on the boiling point of the solvent employed, i.e. sufficient pressure to maintain the solvent in the liquid phase. Reaction times are not critical, and can range from several minutes to 48 hours. In one embodiment, the reactions are carried out under inert atmosphere such as nitrogen or argon.

The reaction is carried out by dissolving the pro-catalyst in a suitable solvent and admixing the appropriate ligand(s) and the salt of the desired weakly coordinating anion with the dissolved pro-catalyst, and optionally heating the solution until the reaction is complete. The preformed single component catalyst can be isolated or can be used directly by adding aliquots of the preformed catalyst in solution to the polymerization medium. Isolation of the product can be

accomplished by standard procedures, such as evaporating the solvent, washing the solid with an appropriate solvent, and then recrystallizing the desired product. The molar ratios of catalyst components employed in the preparation the preformed single component catalyst of the invention is based on the metal contained in the pro-catalyst component. In one embodiment, the molar ratio of pro-catalyst/Group 15 electron donor component/WCA salt is 1:1-10:1-100, In another embodiment, the molar ratio of pro-catalyst/Group 15 electron donor component/WCA salt is 1:1-5:1-20. In yet another embodiment, the molar ratio of pro-catalyst/Group 15 electron donor component/WCA salt is 1:1-2:1-5. In embodiments of the invention where the pro-catalyst is ligated with a Group 15 electron donor ligand and/or a labile neutral electron donor ligand the molar ratio of pro-catalyst (based on the metal content) to WCA salt is 1:1-100. In another embodiment, this ratio is 1:1-20. In yet another embodiment, this ratio is 1:1-5.

In one embodiment, a Group 10 metal pro-catalyst dimer of the formula $[R'MA']_2$ is admixed with a Group 15 electron donor compound, (L'), and a salt of a suitable weakly coordinating anion in an appropriate solvent to produce the single component catalyst product as shown in equation (1) below.



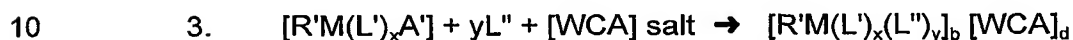
Suitable pro-catalyst dimers of the formula $[R'MA']_2$ include but are not limited to the following compositions (allyl)palladiumtrifluoroacetate dimer, (allyl)palladiumchloride dimer, (crotyl)palladiumchloride dimer, (allyl)palladiumiodide dimer, (β -pinenyl)palladiumchloride dimer, methallylpalladium chloride dimer, 1,1-dimethylallylpalladium chloride dimer, and (allyl)palladiumacetate dimer.

In another embodiment, a ligated Group 10 metal pro-catalyst of the formula $[R'M(L'')_yA']$ is admixed with a Group 15 electron donor compound, (L'), and a salt of a suitable weakly coordinating anion in an appropriate solvent to produce the single component catalyst product as shown in equation (2) below.



A representative pro-catalyst of the formula $[R'M(L'')_yA']$ includes but is not limited to (COD)palladium (methyl)chloride.

5 In a further embodiment, a Group 10 metal ligated pro-catalyst of the formula $[R'M(L')_xA']$ containing the Group 15 electron donor ligand (L') is admixed with a salt of a suitable weakly coordinating anion in an appropriate solvent to produce the single component catalyst product as shown in equation (3) below.



Suitable pro-catalysts of the formula $[R'M(L')_xA']$ include but are not limited to the following compositions:

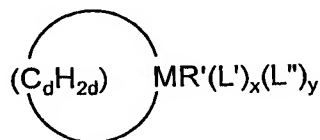
(allyl)palladium(tricyclohexylphosphine)chloride,
 15 (allyl)palladium(tricyclohexylphosphine)triflate,
 (allyl)palladium(triisopropylphosphine)triflate,
 (allyl)palladium(tricyclopentylphosphine)triflate,
 (allyl)palladium(tricyclohexylphosphine)trifluoroacetate (also referred to herein as Allyl Pd-PCy₃TFA),
 20 (allyl)palladium(tri-*o*-tolylphosphine)chloride,
 (allyl)palladium(tri-*o*-tolylphosphine)triflate,
 (allyl)palladium(tri-*o*-tolylphosphine)nitrate,
 (allyl)palladium(tri-*o*-tolylphosphine)acetate,
 (allyl)palladium(triisopropylphosphine)triflimide,
 25 (allyl)palladium(tricyclohexylphosphine)triflimide,
 (allyl)palladium(triphenylphosphine)triflimide,
 (allyl)palladium(trinaphthylphosphine)triflate,
 (allyl)palladium(tricyclohexylphosphine) *p*-tolylsulfonate,
 (allyl)palladium(triphenylphosphine)triflate,
 30 (allyl)palladium(triisopropylphosphine)trifluoroacetate,

- (allyl)platinum(tricyclohexylphosphine)chloride,
 (allyl)platinum(tricyclohexylphosphine)triflate,
 (1,1-dimethylallyl)palladium(triisopropylphosphine)trifluoroacetate.
 (2-chloroallyl)palladium(triisopropylphosphine)trifluoroacetate,
 5 (crotyl)palladium(triisopropylphosphine)triflate,
 (crotyl)palladium(tricyclohexylphosphine)triflate,
 (crotyl)palladium(tricyclopentylphosphine)triflate,
 (methallyl)palladium(tricyclohexylphosphine)triflate,
 (methallyl)palladium(triisopropylphosphine)triflate,
 10 (methallyl)palladium(tricyclopentylphosphine)triflate,
 (methallyl)palladium(tricyclohexylphosphine)chloride,
 (methallyl)palladium(triisopropylphosphine)chloride,
 (methallyl)palladium(tricyclopentylphosphine)chloride,
 (methallyl)palladium(tricyclohexylphosphine)triflimide,
 15 (methallyl)palladium(triisopropylphosphine)triflimide,
 (methallyl)palladium(tricyclopentylphosphine)triflimide,
 (methallyl)palladium(tricyclohexylphosphine)trifluoroacetate,
 (methallyl)palladium(triisopropylphosphine)trifluoroacetate,
 (methallyl)palladium(tricyclopentylphosphine)trifluoroacetate,
 20 (methallyl)palladium(tricyclohexylphosphine)acetate,
 (methallyl)palladium(triisopropylphosphine)acetate,
 (methallyl)palladium(tricyclopentylphosphine)acetate,
 (methallyl)nickel(tricyclohexylphosphine)triflate,
 {2-[(dimethylamino)methyl]phenyl-C,N-}-palladium(tricyclohexyl-
 25 phosphine)chloride,
 [(dimethylamino)methyl]phenyl-C,N-}-palladium(tricyclohexyl-phosphine)triflate,
 (hydrido)palladium bis(tricyclohexylphosphine)triflate,
 (hydrido)palladium bis(tricyclohexylphosphine)formate
 (hydrido)palladium bis(tricyclohexylphosphine)chloride,
 30 (hydrido)palladium bis(triisopropylphosphine)chloride,

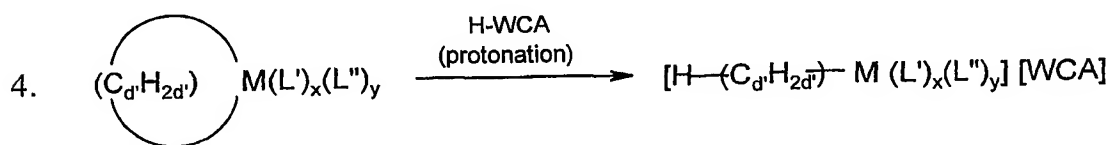
(hydrido)palladium bis(tricyclohexylphosphine)nitrate,
 (hydrido)palladium bis(tricyclohexylphosphine)trifluoroacetate, and
 (hydrido)palladiumbis(triisopropylphosphine)triflate.

Other pro-catalyst components suitable for use in the foregoing process
 include $(\text{Me}_2\text{NCH}_2\text{C}_6\text{H}_4)\text{Pd}(\text{O}_3\text{SCF}_3)\text{P}(\text{cyclohexyl})_3$ (i.e.,
 ortho-metallatedphenylmethylenedimethylamino palladium
 tricyclohexylphosphine), $(\text{allyl})\text{Pd}(\text{P-}i\text{-Pr}_3)\text{C}_6\text{F}_5$, $(\text{allyl})\text{Pd}(\text{PCy}_3)\text{C}_6\text{F}_5$,
 $(\text{CH}_3)\text{Pd}(\text{PMe}_3)_2\text{Cl}$, $(\text{C}_2\text{H}_5)\text{Pd}(\text{PMe}_3)_2\text{Cl}$, $(\text{Ph})\text{Pd}(\text{PMe}_3)_2\text{Cl}$, $(\text{CH}_3)\text{Pd}(\text{PMe}_3)_2\text{Br}$,
 $(\text{CH}_3)\text{Pd}(\text{PMe}_2\text{Ph})_2\text{Cl}$, $(\text{C}_2\text{H}_5)\text{Pd}(\text{PMe}_3)_2\text{Br}$, $(\text{C}_2\text{H}_5)\text{Pd}(\text{PMe}_3)_2\text{Br}$, $(\text{Ph})\text{Pd}(\text{PMe}_3)_2\text{Br}$,
 $(\text{CH}_3)\text{Pd}(\text{PMe}_3)\text{NO}_3$, $(\text{CH}_3)\text{Pd}(\text{P}(i\text{-Pr})_3)_2\text{O}_3\text{SCCF}_3$, $(\eta^1\text{-benzyl})\text{Pd}(\text{PEt}_3)_2\text{Cl}$,
 $(\text{allyl})\text{Pd}(\text{PMe}_3)\text{OC}(\text{O})\text{CH}_2\text{CH}=\text{CH}_2$, $(\text{allyl})\text{Pd}(\text{AsPh}_3)\text{Cl}$, $(\text{allyl})\text{Pd}(\text{PPh}_3)\text{Cl}$,
 $(\text{allyl})\text{Pd}(\text{SbPh}_3)\text{Cl}$, $(\text{methylallyl})\text{Pd}(\text{PPh}_3)\text{Cl}$, $(\text{methylallyl})\text{Pd}(\text{AsPh}_3)\text{Cl}$,
 $(\text{methylallyl})\text{Pd}(\text{SbPh}_3)\text{Cl}$, $(\text{methylallyl})\text{Pd}(\text{PBU}_3)\text{Cl}$, and
 $(\text{methylallyl})\text{Pd}(\text{P}[(\text{OCH}_2)_3\text{CH}]\text{Cl}$.

In another embodiment, the catalyst can be formed by protonating a pro-
 catalyst of the formula:



in the presence of a Brønsted acid based WCA salt or an equivalent reaction
 utilizing a carbonium or silylium based WCA salt to yield an active catalyst as
 illustrated in Eq. 4.



In this embodiment R' is a divalent hydrocarbyl ligand of the formula
 $\text{---}(\text{C}_d\text{H}_{2d})\text{---}$ that is taken together with the Group 10 metal center M to form a
 metallacycle where d' represents the number of carbon atoms in the divalent

hydrocarbyl backbone and is an integer from 3 to 10. Any of the hydrogen atoms on the divalent hydrocarbyl backbone can be replaced by linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, C₅-C₁₀ cycloalkyl, and C₆-C₁₀ aryl. The cycloalkyl and aryl moieties can optionally be substituted with a halogen substituent selected from bromine, chlorine, fluorine, and iodine. In another embodiment, the halogen is fluorine. In addition, any two or three of the alkyl substituents taken together with the hydrocarbyl backbone carbon atoms to which they are attached can form an aliphatic or aromatic ring system. The rings can be monocyclic, polycyclic, or fused. Protonation occurs at one of the hydrocarbyl/metal center bond interfaces to yield a cation complex with a monovalent hydrocarbyl ligand coordinated to the metal center M.

In another embodiment a Group 10 metal ligated pro-catalyst of the formula [R'M(L')_x(L'')_yA'] containing a Group 15 electron donor ligand (L') and a labile neutral electron donor ligand (L'') is admixed with a salt of a suitable weakly coordinating anion in an appropriate solvent to produce the single component catalyst product as shown in equation (5) below.

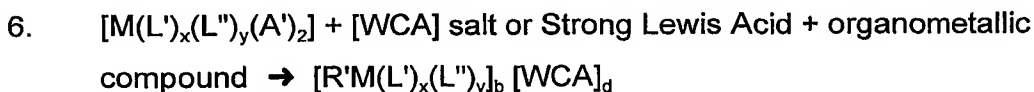


Suitable pro-catalysts of the formula [R'M(L')_x(L'')_yA'] include but are not limited to the following compositions:

[(allyl)Pd(NCCH₃)(P-*i*-Pr₃)] [B(O₂-3,4,5,6-Cl₄C₆)₂], [(allyl)Pd(HOCH₃)(P-*i*-Pr₃)] [B(O₂-3,4,5,6-Cl₄C₆)₂], [(allyl)Pd(HOCH₃)(P-*i*-Pr₃)] [B(O₂-3,4,5,6-Br₄C₆)₂], [(allyl)Pd(HOCH₃)(P-*i*-Pr₃)] [B(O₂C₆H₄)₂], [(allyl)Pd(OEt₂)(P-*i*-Pr₃)] [BPh₄], [(allyl)Pd(OEt₂)(P-*i*-Pr₃)], [SbF₆][(allyl)Pd(OEt₂)(P-*i*-Pr₃)] [BF₄], [(allyl)Pd(OEt₂)(PCy₃)] [BF₄], [(allyl)Pd(OEt₂)(PPh₃)] [BF₄], [(allyl)Pd(OEt₂)(P-*i*-Pr₃)] [PF₆], [(allyl)Pd(OEt₂)(PCy₃)] [PF₆], [(allyl)Pd(OEt₂)(PPh₃)] [PF₆],

[(allyl)Pd(OEt₂)(P-*i*-Pr₃)] [ClO₄], [(allyl)Pd(OEt₂)(PCy₃)] [ClO₄],
 [(allyl)Pd(OEt₂)(PPh₃)] [ClO₄], [(allyl)Pd(OEt₂)(P-*i*-Pr₃)] [SbF₆],
 [(allyl)Pd(OEt₂)(PCy₃)] [SbF₆], and [(allyl)Pd(OEt₂)(PPh₃)] [SbF₆].

In another embodiment of the invention the catalyst of Formula I is
 generated by reacting a pro-catalyst of the formula [M(L')_x(L'')_y(A')₂] with an
 organometallic compound of aluminum, lithium or magnesium, and a source of a
 weakly coordinating anion (WCA) or a strong Lewis Acid. In this embodiment the
 anionic hydrocarbyl ligand (R') on the group 10 metal center (M) is supplied via
 reaction with the organometallic compound to yield the active catalyst as shown
 below.



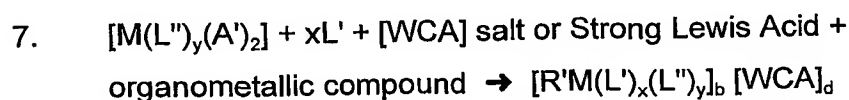
Examples of pro-catalysts suitable for use in this embodiment include :

nickel acetylacetonate,
 nickel carboxylates,
 nickel(II) chloride,
 nickel(II) bromide,
 nickel ethylhexanoate,
 nickel(II) trifluoroacetate,
 nickel(II) hexafluoroacetylacetonate,
 NiCl₂(PPh₃)₂,
 NiBr₂(P(*p*-tolyl)₃)₂,
 trans-PdCl₂(PPh₃)₂,
 palladium(II) bis(trifluoroacetate),
 palladium(II) acetylacetonate,
 (cyclooctadiene)palladium(II) dichloride,
 Pd(acetate)₂(PPh₃)₂,
 PdCl₂(PPh₃)₂

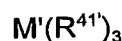
$\text{PdBr}_2(\text{PPh}_3)_2$
 $\text{PdBr}_2(\text{P}(p\text{-tolyl})_3)_2$,
 $\text{PdCl}_2(\text{P}(o\text{-tolyl})_3)_2$,
 $\text{PdCl}_2(\text{P}(\text{cyclohexyl})_3)_2$,
 5 palladium(II) bromide,
 palladium(II) chloride,
 palladium(II) iodide,
 palladium(II) ethylhexanoate,
 dichloro bis(acetonitrile)palladium(II),
 10 dibromo bis(benzonitrile)palladium(II),
 platinum(II) chloride,
 platinum(II) bromide, and
 platinum bis(triphenylphosphine)dichloride.

In general the Group 10 metal pro-catalyst is a nickel(II), platinum(II) or
 15 palladium(II) compound containing two anionic leaving groups (A'), which can be
 readily displaced by the weakly coordinating anion that is provided by the WCA
 salt or strong Lewis acid described below and can be replaced by hydrocarbyl
 groups originating from the organometallic compound. The leaving groups can
 be the same or different. The Group 10 metal pro-catalyst may or may not be
 20 ligated.

When the pro-catalyst of this embodiment is not ligated with a Group 15
 electron donor component (L'), the Group 15 electron donor ligand can be added
 to the reaction medium as shown in the following reaction scheme.

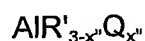


The strong Lewis acids suitable for use in this embodiment are selected
 from compounds of the formula:



wherein M' represents aluminum or boron and R^{41'} represents monosubstituted and multisubstituted C₆-C₃₀ aryl, wherein the substituents on the aryl group are independently selected from halogen (in one embodiment, the halogen is fluorine), linear or branched C₁-C₅ haloalkyl (in one embodiment, trifluoromethyl), and halogenated and perhalogenated phenyl (in one embodiment, pentafluorophenyl). Examples of such strong Lewis acids include: tris(pentafluorophenyl)boron, tris(3,5-bis(trifluoromethyl)phenyl)boron, tris(2,2',2''-nonafluorobiphenyl)borane, and tris(pentafluorophenyl)aluminum.

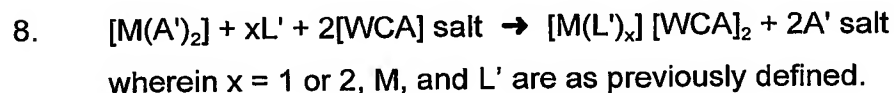
The organometallic compound is a hydrocarbyl derivative of silicon, germanium, tin, lithium, magnesium or aluminum. In one embodiment, aluminum derivatives are utilized. The organoaluminum component of the catalyst system is represented by the formula:



wherein R' independently represents hydrogen, linear or branched C₁-C₂₀ alkyl, C₅-C₁₀ cycloalkyl, linear or branched C₂-C₂₀ alkenyl, C₆-C₁₅ cycloalkenyl, allylic ligands or canonical forms thereof, C₆-C₂₀ aryl, and C₇-C₃₀ aralkyl, Q is a halide or pseudohalide selected from chlorine, fluorine, bromine, iodine, linear and unbranched C₁-C₂₀ alkoxy, C₆-C₂₄ aryloxy; x'' is 0 to 2.5. In another embodiment, x'' is 0 to 2. In yet another embodiment, x'' is 0 to 1. In one embodiment, trialkylaluminum compounds are used. Examples of suitable organometallic compounds include: methyllithium, *sec*-butyllithium, *n*-butyllithium, phenyllithium, butylethylmagnesium, di-*n*-butylmagnesium, butyloctylmagnesium, trimethylaluminum, triethylaluminum, tri-*n*-propylaluminum, tri-*i*-propylaluminum, tri-*i*-butylaluminum, tri-2-methylbutylaluminum, tri-octylaluminum, diethylaluminum chloride, ethylaluminum dichloride, di-*i*-butylaluminum chloride, diethylaluminum bromide, ethylaluminum sesquichloride, diethylaluminum ethoxide,

diethylaluminum(*i*-butylphenoxide), and
diethylaluminum(2,4-di-*tert*-butylphenoxide).

Embodiments of the catalyst devoid of a hydrocarbyl containing ligand
can be synthesized by reacting a pro-catalyst of the formula $[M(A')_2]$ with the
desired ligands and WCA salt in accordance with the following reaction scheme:



Examples of pro-catalyst compounds include palladium(II)
bis(acetylacetonate), palladium (acetate)₂, $Pd(NO_3)_2$, $PdCl_2$, $PdBr_2$, and PdI_2 .

The foregoing schematic equations (1 to 8) have been presented for
illustrative purposes only. While they have been written in balanced form, it
should be recognized that an excess of reaction components can be employed
without deviating from the spirit of invention. For example, an excess of L' , L'' , A' ,
or WCA salt containing components can be employed in the process of the
invention so long as the process is not deleteriously affected.

In a one embodiment the molar ratio of the Group 10 metal/Group 15
electron donor compound/source of a weakly coordinating anion/organometallic
compound is 1:1-10:1-100:2-200. In another embodiment, the molar ratio of the
Group 10 metal/Group 15 electron donor compound/source of a weakly
coordinating anion/organometallic compound is 1:1-5:1-40:4-100. In yet another
embodiment, the molar ratio of the Group 10 metal/Group 15 electron donor
compound/source of a weakly coordinating anion/organometallic compound is
1:1-2:2-20:5-50. In embodiments where the Group 10 metal ion source is an
adduct containing a Group 15 electron donor compound, no additional Group 15
electron donor compound need be employed. In this embodiment the molar ratio
of the Group 10 metal/Group 15 electron donor compound/source of a weakly
coordinating anion/organometallic compound is 1:0:2-20:5-50.

In all of the forgoing embodiments the catalysts of Formula I can be prepared as a preformed single component catalyst in solvent or they can be prepared *in situ* by admixing the precursor components (ligated or non-ligated Group 10 metal component with leaving group(s), ligand component(s), and WCA source or strong Lewis acid source) in the desired monomer, monomer mixtures, or solutions thereof. It is also possible to admix two or even three of the catalyst precursor components and then add the mixture to the monomer or monomer solution containing the remaining catalyst precursor component(s).

In the equations and formulae set forth above and throughout the specification, R', M, L', L'', [WCA], b, d, x, and y are as defined above unless otherwise defined, A' is an anionic leaving group which is defined below, [WCA] salt is a metal salt of the weakly coordinating anion [WCA], and the abbreviations Me, Et, Pr, Bu, Cy, and Ph, as used here and throughout the specification refer to methyl, ethyl, propyl, butyl, cyclohexyl, and phenyl, respectively.

The foregoing Group 10 metal pro-catalyst components are commercially available or can be synthesized by techniques well known in the art.

As discussed above catalyst complex of Formula I can be formed *in situ* by combining any of the Group 10 metal pro-catalysts with the desired catalyst system components in monomer. In cases where the Group 10 metal pro-catalyst already contains the desired ligand groups, the pro-catalyst is mixed in monomer along with the WCA salt or the alternative activators such as strong Lewis acids or Brønsted acids. The WCA salt, strong Lewis acid or Brønsted acid serves as the an activator for the pro-catalyst in the presence of monomer. The *in situ* reactions for preparing the catalysts of Formula I generally follow the same conditions and reaction schemes as outlined for the preparation of the preformed single component catalysts, the principal difference being that the catalysts are formed in monomer in lieu of solvent and that a polymer product is formed.

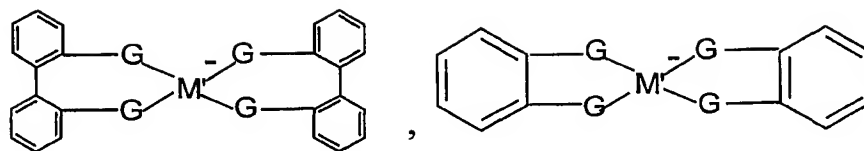
Leaving Groups

A' represents an anionic leaving group that can be readily displaced by the weakly coordinating anion that is provided by the WCA salt. The leaving group forms a salt with the cation on the WCA salt. Leaving group A' is selected from halogen (i.e., Br, Cl, I, and F), nitrate, triflate (trifluoromethanesulfonate), triflimide (bistrifluoromethanesulfonimide), trifluoroacetate, tosylate, AlBr_4^- , AlF_4^- , AlCl_4^- , $\text{AlF}_3\text{O}_3\text{SCF}_3^-$, AsCl_6^- , SbCl_6^- , SbF_6^- , PF_6^- , BF_4^- , ClO_4^- , HSO_4^- , carboxylates, acetates, acetylacetonates, carbonates, aluminates, and borates.

In another embodiment the leaving group can be a hydrocarbyl group or halogenated hydrocarbyl group when a Brønsted acid based WCA salt is utilized as the activator. In this embodiment the activator protonates the hydrocarbyl or halogenated hydrocarbyl forming a neutral moiety. The leaving group moiety is, in one embodiment, selected from the hydride, linear or branched C_1 - C_5 alkyl, linear or branched C_1 - C_5 haloalkyl, C_5 - C_{10} cycloalkyl, and C_6 - C_{10} aryl. The cycloalkyl and aryl moieties can optionally be substituted with a halogen substituent selected from bromine, chlorine, fluorine, and iodine. In one embodiment, the halogen is fluorine. In this embodiment, A' is protonated to yield the neutral moiety A'H. Methyl and pentafluorophenyl groups are representative examples of leaving groups under this embodiment.

Halogen leaving groups include chlorine, iodine, bromine and fluorine. The acetates include groups of the formula $\text{R}^{38'}\text{C}(\text{O})\text{O}^-$, and the carbonates include groups of the formula $\text{R}^{38'}\text{OC}(\text{O})\text{O}^-$, wherein $\text{R}^{38'}$ represents linear or branched C_1 - C_5 alkyl, linear or branched C_1 - C_5 haloalkyl (in one embodiment, the haloalkyl contains only fluorine), linear or branched C_1 - C_5 alkenyl, C_6 - C_{12} aryl, optionally monosubstituted or independently multisubstituted with linear or branched C_1 - C_5 alkyl, linear or branched C_1 - C_5 haloalkyl, and halogen (in one embodiment, fluorine).

The aluminate and borate leaving groups can be represented by the formulae $\text{M}'(\text{R}^{39'})_4^-$, $\text{M}'(\text{GR}^{39'})_4^-$, $\text{M}'(-\text{C}\equiv\text{CPh})_4^-$, or a moiety represented by the following structures:



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wherein G is a sulfur or oxygen atom Ph represents phenyl and substituted phenyl as defined below, and R^{39'} independently represents linear or branched C₁-C₁₀ alkyl, linear or branched C₁-C₁₀ chloro- or bromoalkyl, C₅-C₁₀ cycloalkyl, substituted and unsubstituted aryl (in one embodiment, phenyl and substituted phenyl), substituted and unsubstituted C₇-C₂₀ aralkyl (in one embodiment, phenylalkyl and substituted phenylalkyl). By substituted is meant that the aryl or phenyl groups can contain one or more of linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, chlorine, and bromine substituents, and combinations thereof.

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Representative aluminate groups include but are not limited to tetraphenoxyaluminate, tetrakis(cyclohexanolato)aluminate, tetraethoxyaluminate, tetramethoxyaluminate, tetrakis(isopropoxy)aluminate, tetrakis(2-butanolato)aluminate, tetrapentyloxyaluminate, tetrakis(2-methyl-2-propanolato)aluminate, tetrakis(nonyloxy)aluminate, and bis(2-methoxyethanolate-O,O')bis(2-methoxyethanolate-O')aluminate, tetrakis(phenyl)aluminate, tetrakis(*p*-tolyl)aluminate, tetrakis(*m*-tolyl)aluminate, tetrakis(2,4-dimethylphenyl)aluminate, and tetrakis(3,5-dimethylphenyl)aluminate.

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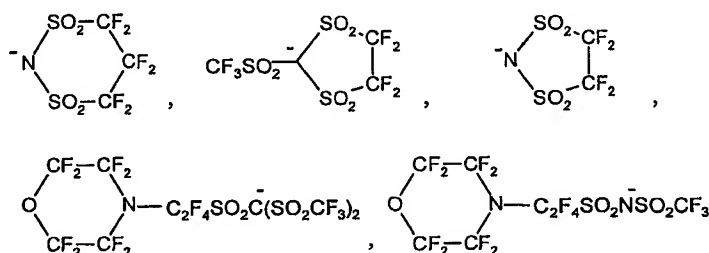
Representative borate groups include tetraphenylborate, tetrakis(4-methylphenyl)borate, tetrakis(4-chlorophenyl)borate, tetrakis(4-bromophenyl)borate, tetrakis(2-bromo-4-chlorophenyl)borate, butyltriphenylborate, tetrakis(4-methoxyphenyl)borate, tetrakis(phenylethynyl)borate, bis(1,2-benzenediolato)borate, triphenyl(phenylethynyl)borate, bis(tetrafluorobenzenediolate)borate, bis(tetrachlorobenzenediolate)borate, bis(tetrabromobenzenediolate)borate,

bis(1,1'-biphenyl-2,2'-diolato)borate, tetrakis(thiophenolyl)borate, bis(3,5-di-*tert*-butylbenzenediolate)borate, tetrakis(2,4-dimethylphenyl)borate, tetrakis(*p*-tolyl)borate, tetrakis(3,5-dimethylphenyl)borate, and tetrakis(*m*-tolyl)borate.

In addition to the anionic leaving groups described above, A' can also be selected from highly fluorinated and perfluorinated alkylsulfonyl and arylsulfonyl containing anions of the formulae $(R^{40'}SO_2)_2CH^-$, $(R^{40'}SO_2)_3C^-$, and $(R^{40'}SO_2)_2N^-$, wherein $R^{40'}$ independently represents linear or branched C_1 - C_{20} highly fluorinated and perfluorinated alkyl, C_5 - C_{15} highly fluorinated and perfluorinated cycloalkyl, and highly fluorinated and perfluorinated C_6 - C_{22} aryl. Optionally, the alkyl and cycloalkyl groups can contain a heteroatom in the chain of cyclic structure, respectively. In one embodiment, the heteroatoms include divalent (non-peroxidic) oxygen (i.e., -O-), trivalent nitrogen, and hexavalent sulfur. Any two of $R^{40'}$ can be taken together to form a ring. When $R^{40'}$ is a cycloalkyl substituent, a heterocycloalkyl substituent, or is taken with another $R^{40'}$ group to form a ring, the ring structures, in one embodiment, contain 5 or 6 atoms, 1 or 2 of which can be heteroatoms.

In the above formulae the term highly fluorinated means that at least 50 percent of the hydrogen atoms bonded to the carbon atoms in the alkyl, cycloalkyl, and aryl moieties are replaced by fluorine atoms. In one embodiment, at least 2 out of every 3 hydrogen atoms on the alkyl, cycloalkyl, and aryl moieties under $R^{40'}$ are replaced by fluorine. In another embodiment, at least 3 out of every 4 hydrogen atoms are replaced by fluorine. In yet another embodiment, all of the hydrogen atoms on the $R^{40'}$ substituent are replaced by fluorine to give the perfluorinated moiety. In addition to or in lieu of fluorine atom substitution on the aryl ring(s), the aryl groups can contain linear or branched C_1 - C_{10} highly fluorinated and perfluorinated alkyl groups, such as, for example, trifluoromethyl. In embodiments where hydrogen atoms remain on the alkyl, cycloalkyl, and aryl moieties, a portion or all of the remaining hydrogen atoms can be replaced with bromine and/or chlorine atoms.

Representative highly fluorinated and perfluorinated alkylsulfonyl and arylsulfonyl containing anions of the foregoing formulae include but are not limited to $(C_2F_5SO_2)_2N^-$, $(C_4F_9SO_2)_2N^-$, $(CF_3SO_2)_2N^-$, $(CF_3SO_2)(C_4F_9SO_2)N^-$, $((CF_3)_2NC_2F_4SO_2)_2N^-$, $(C_6F_5SO_2)(CF_3SO_2)N^-$, $(CF_3SO_2)(CHF_2SO_2)N^-$, $(C_2F_5SO_2)(CF_3SO_2)N^-$, $(C_3F_7SO_2)_2N^-$, $((CF_3)_2(F)CSO_2)_2N^-$, $(C_4F_8(CF_3)_2NSO_2)_2N^-$, $(C_8F_{17}SO_2)_3C^-$, $(CF_3SO_2)_3C^-$, $(CF_3SO_2)_2CH^-$, $(C_4F_9SO_2)_3C^-$, $(CF_3SO_2)_2(C_4F_9SO_2)C^-$, $((CF_3)_2NC_2F_4SO_2)C(SO_2CF_3)_2^-$, $(3,5\text{-bis}(CF_3)C_6H_3)SO_2N(SO_2CF_3)^-$, $(C_6F_5SO_2)C(SO_2CF_3)_2^-$, and the structures exemplified below:



Additional highly fluorinated and perfluorinated alkylsulfonyl and arylsulfonyl anions suitable as leaving groups are described in Turowsky and Seppelt, *Inorganic Chemistry*, 1988, 27, 2135-2137, and in U.S. Patent Numbers 4,387,222; 4,505,997; 5,021,308; 5,072,040; 5,162,177; and 5,273,840 the disclosures of which are hereby incorporated by reference.

WCA SALTS

The salt of the weakly coordinating anion employed in the process of the present invention can be represented by the formula $[C(L'')_z]_b[WCA]_d$, wherein C represents a proton (H^+), an alkaline earth metal cation, a transition metal cation or an organic group containing cation, L'' and WCA, are as defined above, z is an integer from 0 to 8, and b and d represent the number of times the cation complex and weakly coordinating counteranion complex (WCA), respectively, are taken to balance the electronic charge on the overall salt complex.

The alkali metal cations include Group 1 metals selected from lithium, sodium, potassium, rubidium, and cesium. In one embodiment, the Group 1 metal cations are lithium, sodium and potassium.

The alkali earth metal cations include Group 2 metals selected from beryllium, magnesium, calcium, strontium, and barium. In one embodiment, the Group 2 metal cations are magnesium, calcium, strontium, and barium. The transition metal cation is selected from zinc, silver, and thallium.

The organic group cation is selected from ammonium, phosphonium, carbonium and silylium cations, i.e., $[\text{NHR}^{41'}_3]^+$, $[\text{NR}^{41'}_4]^+$, $[\text{PHR}^{41'}_3]$, $[\text{PR}^{41'}_4]$, $[\text{R}^{41'}_3\text{C}]^+$, and $[\text{R}^{41'}_3\text{Si}]^+$, where $\text{R}^{41'}$ independently represents a hydrocarbyl, silylhydrocarbyl, or perfluorocarbyl group, each containing 1 to 24 carbon atoms, (or in another embodiment, from 1 to 12 carbons) arranged in a linear, branched, or ring structure. By perfluorocarbyl is meant that all carbon bonded hydrogen atoms are replaced by a fluorine atom. Representative hydrocarbyl groups include but are not limited to linear or branched C_1 - C_{20} alkyl, C_3 - C_{20} cycloalkyl, linear or branched C_2 to C_{20} alkenyl, C_3 - C_{20} cycloalkenyl, C_6 - C_{24} aryl, and C_7 - C_{24} aralkyl, and organometallic cations. The organic cations are selected from trityl, trimethylsilylium, triethylsilylium, tris(trimethylsilyl)silylium, tribenzylsilylium, triphenylsilylium, tricyclohexylsilylium, dimethyloctadecylsilylium, and triphenylcarbenium (i.e., trityl). In addition to the above cation complexes ferrocenium cations such as $[(\text{C}_5\text{H}_5)_2\text{Fe}]^+$ and $[(\text{C}_5(\text{CH}_3))_2\text{Fe}]^+$ are also useful as the cation in the WCA salts of the invention.

Examples of WCA salts having a weakly coordinating anion described under Formula II include but are not limited to lithium tetrakis(2-fluorophenyl)borate, sodium tetrakis(2-fluorophenyl)borate, silver tetrakis(2-fluorophenyl)borate, thallium tetrakis(2-fluorophenyl)borate, lithium tetrakis(3-fluorophenyl)borate, sodium tetrakis(3-fluorophenyl)borate,

silver tetrakis(3-fluorophenyl)borate,
thallium tetrakis(3-fluorophenyl)borate,
ferrocenium tetrakis(3-fluorophenyl)borate,
ferrocenium tetrakis(pentafluorophenyl)borate,
5 lithium tetrakis(4-fluorophenyl)borate,
sodium tetrakis(4-fluorophenyl)borate,
silver tetrakis(4-fluorophenyl)borate,
thallium tetrakis(4-fluorophenyl)borate,
lithium tetrakis(3,5-difluorophenyl)borate,
10 sodium tetrakis(3,5-difluorophenyl)borate,
thallium tetrakis(3,5-difluorophenyl)borate,
trityl tetrakis(3,5-difluorophenyl)borate,
2,6-dimethylanilinium tetrakis(3,5-difluorophenyl)borate,
lithium tetrakis(pentafluorophenyl)borate,
15 lithium(diethyl ether) tetrakis(pentafluorophenyl)borate,
lithium(diethyl ether)_{2.5} tetrakis(pentafluorophenyl)borate (also referred to herein
as LiFABA),
lithium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
lithium tetrakis(3,4,5,6-tetrafluorophenyl)borate,
20 lithium tetrakis(1,2,2-trifluoroethylenyl)borate,
lithium tetrakis(3,4,5-trifluorophenyl)borate,
lithium methyltris(perfluorophenyl)borate,
lithium phenyltris(perfluorophenyl)borate,
lithium tris(isopropanol) tetrakis(pentafluorophenyl)borate,
25 lithium tetrakis(methanol) tetrakis(pentafluorophenyl)borate,
silver tetrakis(pentafluorophenyl)borate,
tris(toluene)silver tetrakis(pentafluorophenyl)borate,
tris(xylene)silver tetrakis(pentafluorophenyl)borate,
trityl tetrakis(pentafluorophenyl)borate,
30 trityl tetrakis(4-triisopropylsilyltetrafluorophenyl)borate,

trityl tetrakis(4-dimethyl-*tert*-butylsilyltetrafluorophenyl)borate,
thallium tetrakis[3,5-bis(trifluoromethyl)phenyl]borate,
2,6-dimethylanilinium tetrakis(pentafluorophenyl)borate,
N,N-dimethylanilinium tetrakis(pentafluorophenyl)borate,
5 N,N-dimethylanilinium tetrakis[3,5-bis(trifluoromethyl)phenyl]borate
lithium (triphenylsiloxy)tris(pentafluorophenyl)borate,
sodium (triphenylsiloxy)tris(pentafluorophenyl)borate,
sodium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
sodium tetrakis(3,4,5,6-tetrafluorophenyl)borate,
10 sodium tetrakis(1,2,2-trifluoroethylenyl)borate,
sodium tetrakis(3,4,5-trifluorophenyl)borate,
sodium methyltris(perfluorophenyl)borate,
sodium phenyltris(perfluorophenyl)borate,
thallium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
15 thallium tetrakis(3,4,5,6-tetrafluorophenyl)borate,
thallium tetrakis(1,2,2-trifluoroethylenyl)borate,
thallium tetrakis(3,4,5-trifluorophenyl)borate,
sodium methyltris(perfluorophenyl)borate,
thallium phenyltris(perfluorophenyl)borate,
20 trityl tetrakis(2,3,4,5-tetrafluorophenyl)borate,
trityl tetrakis(3,4,5,6-tetrafluorophenyl)borate,
trityl tetrakis(1,2,2-trifluoroethylenyl)borate,
trityl tetrakis(3,4,5-trifluorophenyl)borate,
trityl methyltris(pentafluorophenyl)borate,
25 trityl phenyltris(perfluorophenyl)borate,
silver tetrakis[3,5-bis(trifluoromethyl)phenyl]borate,
silver(toluene) tetrakis[3,5-bis(trifluoromethyl)phenyl]borate,
thallium tetrakis[3,5-bis(trifluoromethyl)phenyl]borate,
lithium (hexyltris(pentafluorophenyl)borate,
30 lithium triphenylsiloxytris(pentafluorophenyl)borate,

lithium(octyloxy)tris(pentafluorophenyl)borate,
lithium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate,
sodium tetrakis(pentafluorophenyl)borate,
trityl tetrakis(pentafluorophenyl)borate,
5 sodium(octyloxy)tris(pentafluorophenyl)borate,
sodium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate,
potassium tetrakis(pentafluorophenyl)borate,
trityl tetrakis(pentafluorophenyl)borate,
potassium(octyloxy)tris(pentafluorophenyl)borate,
10 potassium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate,
magnesium tetrakis(pentafluorophenyl)borate,
magnesium magnesium(octyloxy)tris(pentafluorophenyl)borate,
magnesium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate,
calcium tetrakis(pentafluorophenyl)borate,
15 calcium (octyloxy)tris(pentafluorophenyl)borate,
calcium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate,
lithium tetrakis[3,5-bis[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]phenyl]borate,
sodium tetrakis[3,5-bis[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]phenyl]borate,
20 silver tetrakis[3,5-bis[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]phenyl]borate,
thallium tetrakis[3,5-bis[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]phenyl]borate,
25 lithium tetrakis[3-[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
sodium tetrakis[3-[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
silver tetrakis[3-[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
30

thallium tetrakis[3-[1-methoxy-2,2,2-trifluoro-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
lithium tetrakis[3-[2,2,2-trifluoro-1-(2,2,2-trifluoroethoxy)-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
5 sodium tetrakis[3-[2,2,2-trifluoro-1-(2,2,2-trifluoroethoxy)-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
silver tetrakis[3-[2,2,2-trifluoro-1-(2,2,2-trifluoroethoxy)-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
thallium tetrakis[3-[2,2,2-trifluoro-1-(2,2,2-trifluoroethoxy)-1-(trifluoromethyl)ethyl]-5-(trifluoromethyl)phenyl]borate,
10 trimethylsilylium tetrakis(pentafluorophenyl)borate,
trimethylsilylium etherate tetrakis(pentafluorophenyl)borate,
triethylsilylium tetrakis(pentafluorophenyl)borate,
triphenylsilylium tetrakis(pentafluorophenyl)borate,
15 tris(mesityl)silylium tetrakis(pentafluorophenyl)borate,
tribenzylsilylium tetrakis(pentafluorophenyl)borate,
trimethylsilylium methyltris(pentafluorophenyl)borate,
triethylsilylium methyltris(pentafluorophenyl)borate,
triphenylsilylium methyltris(pentafluorophenyl)borate,
20 tribenzylsilylium methyltris (pentafluorophenyl)borate,
trimethylsilylium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
triethylsilylium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
triphenylsilylium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
tribenzylsilylium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
25 trimethylsilylium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
triphenylsilylium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
trimethylsilylium tetrakis(3,4,5-trifluorophenyl)borate,
tribenzylsilylium tetrakis(3,4,5-trifluorophenyl)aluminate,
triphenylsilylium methyltris(3,4,5-trifluorophenyl)aluminate,
30 triethylsilylium tetrakis(1,2,2-trifluoroethenyl)borate,

tricyclohexylsilylium tetrakis(2,3,4,5-tetrafluorophenyl)borate,
 dimethyloctadecylsilylium tetrakis(pentafluorophenyl)borate,
 tris(trimethyl)silyl)silylium methyltri(2,3,4,5-tetrafluorophenyl)borate, 2,2'-dimethyl-
 1,1'-binaphthylmethylsilylium tetrakis(pentafluorophenyl)borate,
 5 2,2'-dimethyl-1,1'-binaphthylmethylsilylium
 tetrakis(3,5-bis(trifluoromethyl)phenyl)borate,
 lithium tetrakis(pentafluorophenyl)aluminate,
 trityl tetrakis(pentafluorophenyl)aluminate,
 trityl (perfluorobiphenyl)fluoroaluminate,
 10 lithium(octyloxy)tris(pentafluorophenyl)aluminate,
 lithium tetrakis(3,5-bis(trifluoromethyl)phenyl)aluminate,
 sodium tetrakis(pentafluorophenyl)aluminate,
 trityl tetrakis(pentafluorophenyl)aluminate,
 sodium(octyloxy)tris(pentafluorophenyl)aluminate,
 15 sodium tetrakis(3,5-bis(trifluoromethyl)phenyl)aluminate,
 potassium tetrakis(pentafluorophenyl)aluminate,
 trityl tetrakis(pentafluorophenyl)aluminate,
 potassium (octyloxy)tris(pentafluorophenyl)aluminate,
 potassium tetrakis(3,5-bis(trifluoromethyl)phenyl)aluminate,
 20 magnesium tetrakis(pentafluorophenyl)aluminate,
 magnesium(octyloxy)tris(pentafluorophenyl)aluminate,
 magnesium tetrakis(3,5-bis(trifluoromethyl)phenyl)aluminate,
 calcium tetrakis(pentafluorophenyl)aluminate,
 calcium (octyloxy)tris(pentafluorophenyl)aluminate, and
 25 calcium tetrakis(3,5-bis(trifluoromethyl)phenyl)aluminate.

Examples of WCA salts having a weakly coordinating anion described under
 Formula III include but are not limited to $\text{LiB}(\text{OC}(\text{CF}_3)_3)_4$, $\text{LiB}(\text{OC}(\text{CF}_3)_2(\text{CH}_3))_4$,
 $\text{LiB}(\text{OC}(\text{CF}_3)_2\text{H})_4$, $\text{LiB}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$, $\text{TIB}(\text{OC}(\text{CF}_3)_3)_4$, $\text{TIB}(\text{OC}(\text{CF}_3)_2\text{H})_4$,
 $\text{TIB}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$, $\text{TIB}(\text{OC}(\text{CF}_3)_2(\text{CH}_3))_4$, $(\text{Ph}_3\text{C})\text{B}(\text{OC}(\text{CF}_3)_3)_4$,
 30 $(\text{Ph}_3\text{C})\text{B}(\text{OC}(\text{CF}_3)_2(\text{CH}_3))_4$, $(\text{Ph}_3\text{C})\text{B}(\text{OC}(\text{CF}_3)_2\text{H})_4$, $(\text{Ph}_3\text{C})\text{B}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$,

$\text{AgB}(\text{OC}(\text{CF}_3)_3)_4$, $\text{AgB}(\text{OC}(\text{CF}_3)_2\text{H})_4$, $\text{AgB}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$, $\text{LiB}(\text{O}_2\text{C}_6\text{F}_4)_2$,
 $\text{TIB}(\text{O}_2\text{C}_6\text{F}_4)_2$, $\text{Ag}(\text{toluene})_2\text{B}(\text{O}_2\text{C}_6\text{F}_4)_2$, and $\text{Ph}_3\text{CB}(\text{O}_2\text{C}_6\text{F}_4)_2$, $\text{LiB}(\text{OCH}_2(\text{CF}_3)_2)_4$,
 $[\text{Li}(\text{HOCH}_3)_4]\text{B}(\text{O}_2\text{C}_6\text{Cl}_4)_2$, $[\text{Li}(\text{HOCH}_3)_4]\text{B}(\text{O}_2\text{C}_6\text{F}_4)_2$, $[\text{Ag}(\text{toluene})_2]\text{B}(\text{O}_2\text{C}_6\text{Cl}_4)_2$,
 $\text{LiB}(\text{O}_2\text{C}_6\text{Cl}_4)_2$, $(\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{Ph})_4)$, $(\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{Ph})_4)$, $(\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{Ph})_4)$,
5 $(\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{Ph})_4)$, $(\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{CH}_3)_4)$, $(\text{ThAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{CH}_3)_4)$,
 $(\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{CH}_3)_4)$, $(\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{CH}_3)_4)$, $\text{LiAl}(\text{OC}(\text{CF}_3)_3)_4$,
 $\text{ThAl}(\text{OC}(\text{CF}_3)_3)_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_3)_4$, $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_3)_4$, $\text{LiAl}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$,
 $\text{TlAl}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$, $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)(\text{CH}_3)\text{H})_4$,
 $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{H})_4$, $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{H})_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{H})_4$, $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{H})_4$,
10 $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}i\text{-Pr})_4$, $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}i\text{-Pr})_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}i\text{-Pr})_4$,
 $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}i\text{-Pr})_4$, $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}t\text{-butyl})_4$, $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}t\text{-butyl})_4$,
 $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}t\text{-butyl})_4$, $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-}t\text{-butyl})_4$,
 $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-SiMe}_3)_4$, $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-SiMe}_3)_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-SiMe}_3)_4$,
 $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-SiMe}_3)_4$, $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-Si-}i\text{-Pr}_3)_4$,
15 $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-Si-}i\text{-Pr}_3)_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-Si-}i\text{-Pr}_3)_4$,
 $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_4\text{-4-Si-}i\text{-Pr}_3)_4$, $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,6-(CF}_3)_2\text{-4-Si-}i\text{-Pr}_3)_4$,
 $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,6-(CF}_3)_2\text{-4-Si-}i\text{-Pr}_3)_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,6-(CF}_3)_2\text{-4-Si-}i\text{-Pr}_3)_4$,
 $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,6-(CF}_3)_2\text{-4-Si-}i\text{-Pr}_3)_4$, $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_3\text{-3,5-(CF}_3)_2)_4$,
 $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_3\text{-3,5-(CF}_3)_2)_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_3\text{-3,5-(CF}_3)_2)_4$,
20 $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_3\text{-3,5-(CF}_3)_2)_4$, $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,4,6-(CF}_3)_3)_4$,
 $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,4,6-(CF}_3)_3)_4$, $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,4,6-(CF}_3)_3)_4$,
 $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{H}_2\text{-2,4,6-(CF}_3)_3)_4$, $\text{LiAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{F}_5)_4$, $\text{TlAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{F}_5)_4$,
 $\text{AgAl}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{F}_5)_4$, and $\text{Ph}_3\text{CAI}(\text{OC}(\text{CF}_3)_2\text{C}_6\text{F}_5)_4$.

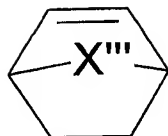
Examples of boratobenzene salts include but are not limited to [1,4-dihydro-4-
 25 methyl-1-(pentafluorophenyl)]-2-borinyl lithium, [1,4-dihydro-4-methyl-1-
 (pentafluorophenyl)]-2-borinyl triphenylmethylium, 4-(1,1-dimethyl)-1,2-dihydro-1-
 (pentafluorophenyl)-2-borinyl lithium, 4-(1,1-dimethyl)-1,2-dihydro-1-
 (pentafluorophenyl)-2-borinyl triphenylmethylium, 1-fluoro-1,2-dihydro-4-
 (pentafluorophenyl)-2-borinyl lithium, 1-fluoro-1,2-dihydro-4-(pentafluorophenyl)-2-

borinyl triphenylmethylium, 1-[3,5-bis(trifluoromethyl)phenyl]-1,2-dihydro-4-(pentafluorophenyl)-2-borinyl lithium, and 1-[3,5-bis(trifluoromethyl)phenyl]-1,2-dihydro-4-(pentafluorophenyl)-2-borinyl triphenylmethylium.

Examples of WCA carborane and halocarborane salts include but are not limited to silver dodecahydro-1-carbadodecaborate, $\text{LiCB}_{11}(\text{CH}_3)_{12}$, $\text{LiCB}_{11}\text{H}_{12}$, $(\text{Me}_3\text{NH})[\text{CB}_{11}\text{H}_{12}]$, $(\text{Me}_4\text{N})[1-\text{C}_2\text{H}_5\text{CB}_{11}\text{H}_{11}]$, $(\text{Me}_4\text{N})[1-\text{Ph}_3\text{SiCB}_{11}\text{H}_{11}]$, $(\text{Me}_4\text{N})[1-\text{CF}_3\text{CB}_{11}\text{H}_{11}]$, $\text{Cs}[12-\text{BrCB}_{11}\text{H}_{11}]$, $\text{Ag}[12-\text{BrCB}_{11}\text{H}_{11}]$, $\text{Cs}[7,12-\text{Br}_2\text{CB}_{11}\text{H}_{10}]$, $\text{Cs}[12-\text{ClCB}_{11}\text{H}_{11}]$, $\text{Cs}[7,12-\text{Cl}_2\text{CB}_{11}\text{H}_{10}]$, $\text{Cs}[1-\text{H-CB}_{11}\text{F}_{11}]$, $\text{Cs}[1-\text{CH}_3-\text{CB}_{11}\text{F}_{11}]$, $(i\text{-Pr}_3\text{Si})[1-\text{CF}_3-\text{CB}_{11}\text{F}_{11}]$, $\text{Li}[12-\text{CB}_{11}\text{H}_{11}\text{F}]$, $\text{Li}[7,12-\text{CB}_{11}\text{H}_{11}\text{F}_2]$, $\text{Li}[7,9,12-\text{CB}_{11}\text{H}_{11}\text{F}_3]$, $(i\text{-Pr}_3\text{Si})[\text{CB}_{11}\text{H}_6\text{Br}_6]$, $\text{Cs}[\text{CB}_{11}\text{H}_6\text{Br}_6]$, $\text{Li}[6-\text{CB}_9\text{H}_9\text{F}]$, $\text{Li}[6,8-\text{CB}_9\text{H}_8\text{F}_2]$, $\text{Li}[6,7,8-\text{CB}_9\text{H}_7\text{F}_3]$, $\text{Li}[6,7,8,9-\text{CB}_9\text{H}_6\text{F}_4]$, $\text{Li}[2,6,7,8,9-\text{CB}_9\text{H}_5\text{F}_5]$, $\text{Li}[\text{CB}_9\text{H}_5\text{Br}_5]$, $\text{Ag}[\text{CB}_{11}\text{H}_6\text{Cl}_6]$, $\text{Ti}[\text{CB}_{11}\text{H}_6\text{Cl}_6]$, $\text{Ag}[\text{CB}_{11}\text{H}_6\text{F}_6]$, $\text{Ti}[\text{CB}_{11}\text{H}_6\text{F}_6]$, $\text{Ag}[\text{CB}_{11}\text{H}_6\text{I}_6]$, $\text{Ti}[\text{CB}_{11}\text{H}_6\text{I}_6]$, $\text{Ag}[\text{CB}_{11}\text{H}_6\text{Br}_6]$, $\text{Ti}[\text{CB}_{11}\text{H}_6\text{Br}_6]$, $\text{Li}[6,7,9,10,11,12-\text{CB}_{11}\text{H}_6\text{F}_6]$, $\text{Li}[2,6,7,8,9,10-\text{CB}_9\text{H}_5\text{F}_5]$, $\text{Li}[1-\text{H-CB}_9\text{F}_9]$, $\text{Ti}[12-\text{CB}_{11}\text{H}_{11}(\text{C}_6\text{H}_5)]$, $\text{Ag}[1-\text{C}_6\text{F}_5-\text{CB}_{11}\text{H}_5\text{Br}_6]$, $\text{Li}[\text{CB}_{11}\text{Me}_{12}]$, $\text{Li}[\text{CB}_{11}(\text{CF}_3)_{12}]$, $\text{Li}[\text{CB}_{11}\text{H}_6\text{I}_6]$, $\text{Li}[\text{CB}_9\text{H}_5\text{Br}_5]$, $\text{Li}[\text{Co}(\text{B}_9\text{C}_2\text{H}_{11})_2]$, $\text{Li}[\text{CB}_{11}(\text{CH}_3)_{12}]$, $\text{Li}[\text{CB}_{11}(\text{C}_4\text{H}_9)_{12}]$, $\text{Li}[\text{CB}_{11}(\text{C}_6\text{H}_{13})_{12}]$, $\text{Na}[\text{Co}(\text{C}_2\text{B}_9\text{H}_{11})_2]$, and $\text{Na}[\text{Co}(\text{Br}_3\text{C}_2\text{B}_9\text{H}_8)_2]$. Additional halocarborane salts are disclosed in International Patent Publication WO 98/43983, which is hereby incorporated by reference.

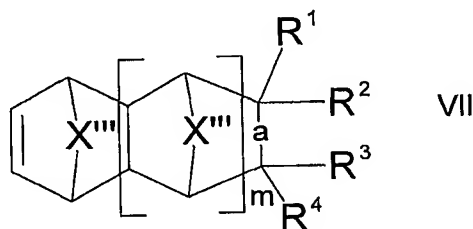
Monomers

The catalysts of the present invention are suitable for the preparation of a wide range of polymers comprising cyclic repeating units. The cyclic polymers are prepared by the addition polymerization of a polycycloolefin monomer(s) in the presence of a catalytic amount of a catalyst of Formula I or the pro-catalyst components described above. The monomer(s) can be polymerized via solution or mass polymerization techniques. As stated herein the terms "polycycloolefin," "polycyclic," and "norbornene-type" monomer are used interchangeably and mean that the monomer contains at least one norbornene moiety as shown below:



where X''' represents oxygen, nitrogen with hydrogen or a C₁ to C₁₀ alkyl linear or branched being bonded thereto, sulfur or a methylene group of the formula -(CH₂)_{n'}- where n' is an integer of 1 to 5.

The simplest polycyclic monomer of the invention is the bicyclic monomer, bicyclo[2.2.1]hept-2-ene, commonly referred to as norbornene. The term norbornene-type monomer is meant to include norbornene, substituted norbornene(s), and any substituted and unsubstituted higher cyclic derivatives thereof so long as the monomer contains at least one norbornene-type or substituted norbornene-type moiety. In one embodiment, the substituted norbornene-type monomers and higher cyclic derivatives thereof contain a pendant hydrocarbyl substituent(s) or a pendant functional substituent(s) containing an oxygen atom. In one embodiment, the norbornene-type or polycycloolefin monomers are represented by the structure below:



wherein each X''' is independently defined as above, "a" represents a single or double bond, R¹ to R⁴ independently represent a hydrogen, hydrocarbyl or functional substituent, m is an integer from 0 to 5, and when "a" is a double bond one of R¹, R² and one of R³, R⁴ are not present.

When the substituent is a hydrocarbyl group, R¹ to R⁴ can be a halohydrocarbyl, or perhalohydrocarbyl group, or even a perhalocarbyl group (e.g., a trifluormethyl group). In one embodiment, R¹ to R⁴ independently represent

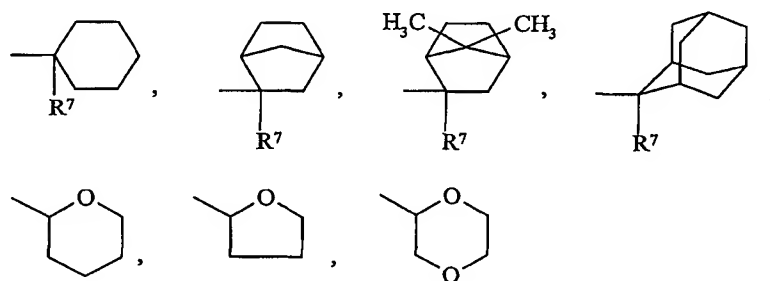
hydrocarbyl, halogenated hydrocarbyl and perhalogenated hydrocarbyl groups selected from hydrogen, linear or branched C₁-C₁₀ alkyl, linear or branched, C₂-C₁₀ alkenyl, linear or branched C₂-C₁₀ alkynyl, C₄-C₁₂ cycloalkyl, C₄-C₁₂ cycloalkenyl, C₆-C₁₂ aryl, and C₇-C₂₄ aralkyl, R¹ and R² or R³ and R⁴ can be taken together to represent a C₁-C₁₀ alkylidenyl group. Representative alkyl groups include but are not limited to methyl, ethyl, propyl, isopropyl, butyl, isobutyl, sec-butyl, tert-butyl, pentyl, neopentyl, hexyl, heptyl, octyl, nonyl, and decyl. Representative alkenyl groups include but are not limited to vinyl, allyl, butenyl, and cyclohexenyl. Representative alkynyl groups include but are not limited to ethynyl, 1-propynyl, 2-propynyl, 1-butylnyl, and 2-butylnyl. Representative cycloalkyl groups include but are not limited to cyclopentyl, cyclohexyl, and cyclooctyl substituents. Representative aryl groups include but are not limited to phenyl, naphthyl, and anthracenyl. Representative aralkyl groups include but are not limited to benzyl, and phenethyl. Representative alkylidenyl groups include methylidenyl, and ethylidenyl, groups.

In one embodiment, the perhalohydrocarbyl groups include perhalogenated phenyl and alkyl groups. The halogenated alkyl groups useful in the invention are partially or fully halogenated and are linear or branched, and have the formula C_zX"_{2z+1} wherein X" is independently a halogen as set forth above or a hydrogen and z is selected from an integer of 1 to 20. In another embodiment, each X" is independently selected from hydrogen, chlorine, fluorine and/or bromine. In yet another embodiment, each X" is independently either a hydrogen or a fluorine.

In one embodiment, the perfluorinated substituents include perfluorophenyl, perfluoromethyl, perfluoroethyl, perfluoropropyl, perfluorobutyl, and perfluorohexyl. In addition to the halogen substituents, the cycloalkyl, aryl, and aralkyl groups of the invention can be further substituted with linear or branched C₁-C₅ alkyl and haloalkyl groups, aryl groups and cycloalkyl groups.

When the pendant group(s) is a functional substituent, R¹ to R⁴ independently represent a radical selected from (CH₂)_n-CH(CF₃)₂-O-Si(Me)₃, -(CH₂)_n-CH(CF₃)₂-O-CH₂-O-CH₃, -(CH₂)_n-CH(CF₃)₂-O-C(O)-O-C(CH₃)₃, -(CH₂)_n-C(CF₃)₂-OH, -(CH₂)_n-C(O)NH₂, -(CH₂)_n-C(O)Cl, -(CH₂)_n-C(O)OR⁵, -(CH₂)_n-OR⁵, -

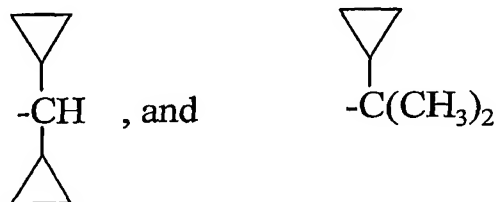
$(\text{CH}_2)_n\text{-OC(O)R}^5$, $(\text{CH}_2)_n\text{-C(O)R}^5$, $(\text{CH}_2)_n\text{-OC(O)OR}^5$, $(\text{CH}_2)_n\text{Si(R}^5)_3$, $(\text{CH}_2)_n\text{Si(OR}^5)_3$,
 $(\text{CH}_2)_n\text{-O-Si(R}^5)_3$, and $(\text{CH}_2)_n\text{C(O)OR}^6$ wherein n independently represents an
 integer from 0 to 10 and R^5 independently represents hydrogen, linear or branched
 $\text{C}_1\text{-C}_{20}$ alkyl, linear or branched $\text{C}_1\text{-C}_{20}$ halogenated or perhalogenated alkyl, linear or
 branched $\text{C}_2\text{-C}_{10}$ alkenyl, linear or branched $\text{C}_2\text{-C}_{10}$ alkynyl, $\text{C}_5\text{-C}_{12}$ cycloalkyl, $\text{C}_6\text{-C}_{14}$
 aryl, $\text{C}_6\text{-C}_{14}$ halogenated or perhalogenated aryl, and $\text{C}_7\text{-C}_{24}$ aralkyl. Representative
 hydrocarbonyl groups set forth under the definition of R^5 are the same as those
 identified above under the definition of R^1 to R^4 . As set forth above under R^1 to R^4
 the hydrocarbonyl groups defined under R^5 can be halogenated and perhalogenated.
 For example, when R^5 is $\text{C}_1\text{-C}_{20}$ halogenated or perhalogenated alkyl, R^5 can be
 represented by the formula $\text{C}_z\text{X}''_{2z+1}$, wherein z and X'' are defined as above, and at
 least one X'' on the alkyl group must be a halogen (e.g., Br, Cl, or F). It is to be
 recognized that when the alkyl group is perhalogenated, all X'' substituents are
 halogenated. Examples of perhalogenated alkyl groups include, but are not limited
 to, trifluoromethyl, trichloromethyl, $\text{-C}_7\text{F}_{15}$, and $\text{-C}_{11}\text{F}_{23}$. Examples of perhalogenated
 aryl groups include, but are not limited to, pentachlorophenyl and pentafluorophenyl.
 The R^6 radical represents an acid labile moiety selected from $\text{-C(CH}_3)_3$, $\text{-Si(CH}_3)_3$,
 $\text{-CH(R}^7\text{)OCH}_2\text{CH}_3$, $\text{-CH(R}^7\text{)OC(CH}_3)_3$ or the following cyclic groups:



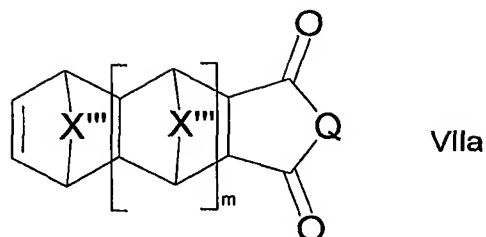
wherein R^7 represents hydrogen or a linear or branched ($\text{C}_1 - \text{C}_5$) alkyl group. The
 alkyl groups include methyl, ethyl, propyl, *i*-propyl, butyl, *i*-butyl, *t*-butyl, pentyl, *t*-
 pentyl and neopentyl. In the above structures, the single bond line projecting from
 the cyclic groups indicates the position where the cyclic protecting group is bonded
 to the acid substituent. Examples of R^6 radicals include 1-methyl-1-cyclohexyl,

isobornyl, 2-methyl-2-isobornyl, 2-methyl-2-adamantyl, tetrahydrofuranyl, tetrahydropyranoyl, 3-oxocyclohexanonyl, mevalonic lactonyl, 1-ethoxyethyl, and 1-t-butoxy ethyl.

The R⁶ radical can also represent dicyclopropylmethyl (Dcpm), and dimethylcyclopropylmethyl (Dmcp) groups which are represented by the following structures:

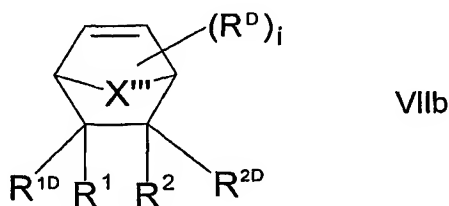


In Structure VII above, R¹ and R⁴ together with the two ring carbon atoms to which they are attached can represent a substituted or unsubstituted cycloaliphatic group containing 4 to 30 ring carbon atoms or a substituted or unsubstituted aryl group containing 6 to 18 ring carbon atoms or combinations thereof. The cycloaliphatic group can be monocyclic or polycyclic. When unsaturated the cyclic group can contain monounsaturations or multiunsaturations. In one embodiment, the unsaturated cyclic group is a monounsaturated cyclic group. When substituted, the rings contain monosubstitution or multisubstitution wherein the substituents are independently selected from hydrogen, linear or branched C₁-C₅ alkyl, linear or branched C₁-C₅ haloalkyl, linear or branched C₁-C₅ alkoxy, halogen, or combinations thereof. R¹ and R⁴ can be taken together to form the divalent bridging group, -C(O)-Q-(O)C-, which when taken together with the two ring carbon atoms to which they are attached form a pentacyclic ring, wherein Q represents an oxygen atom or the group N(R⁸), and R⁸ is selected from hydrogen, halogen, linear or branched C₁-C₁₀ alkyl, and C₆-C₁₈ aryl. A representative structure is shown in below.



wherein each X''' is independently defined as above and m is an integer from 0 to 5.

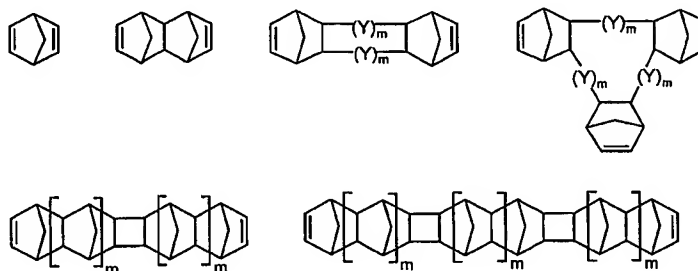
Deuterium enriched norbornene-type monomers wherein at least one of the hydrogen atoms on the norbornene-type moiety and/or one at least one of the hydrogen atoms on a pendant hydrocarbyl substituent described under R^1 to R^4 have been replaced by a deuterium atom are contemplated within the scope of the present invention. In one embodiment, at least 40 percent of the hydrogen atoms on the norbornene-type moiety and/or the hydrocarbyl substituent are replaced by deuterium. In another embodiment, at least about 50 percent of the hydrogen atoms on the norbornene-type moiety and/or the hydrocarbyl substituent are replaced by deuterium. In yet another embodiment, at least about 60 percent of the hydrogen atoms on the norbornene-type moiety and/or the hydrocarbyl substituent are replaced by deuterium. In one embodiment, the deuterated monomers are represented by the structure below:



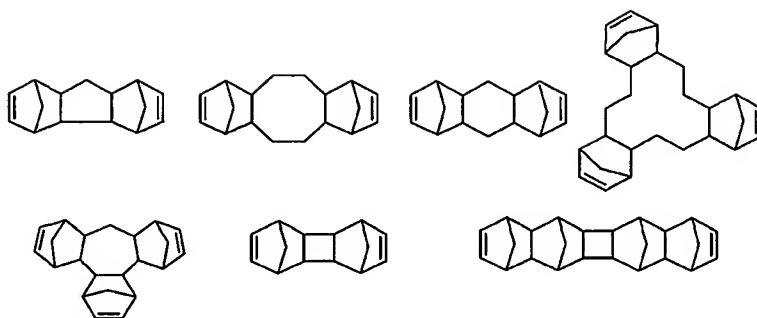
wherein X''' is defined as above, R^D is deuterium, " i " is an integer ranging from 0 to 6, with the proviso that when " i " is 0, at least one of R^1D and R^2D must be present, R^1 and R^2 independently represent a hydrocarbyl or functional substituent as defined above, and R^1D and R^2D may or may not be present and independently represent a deuterium atom or a deuterium enriched hydrocarbyl group containing at least one

deuterium atom. In one embodiment, the deuterated hydrocarbyl group is selected from linear or branched C₁-C₁₀ alkyl wherein at least 40 percent of the hydrogen atoms on the carbon backbone are replaced by deuterium. In another embodiment, the deuterated hydrocarbyl group is selected from linear or branched C₁-C₁₀ alkyl wherein at least 50 percent of the hydrogen atoms on the carbon backbone are replaced by deuterium. In yet another embodiment, the deuterated hydrocarbyl group is selected from linear or branched C₁-C₁₀ alkyl wherein at least 60 percent of the hydrogen atoms on the carbon backbone are replaced by deuterium.

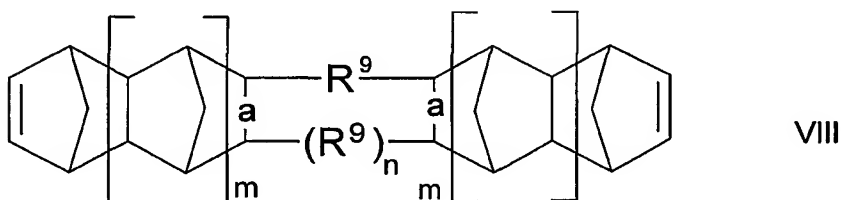
Crosslinked polymers can be prepared by copolymerizing the norbornene-type monomer(s) set forth under Structure VII above with a multifunctional norbornene-type crosslinking monomer(s). By multifunctional norbornene-type crosslinking monomer is meant that the crosslinking monomer contains at least two norbornene-type moieties (norbornene-type double bonds), each functionality being polymerizable in the presence of the catalyst system of the present invention. The crosslinkable monomers include fused multicyclic ring systems and linked multicyclic ring systems. Examples of fused crosslinking agents are illustrated in structures below. For brevity, norbornadiene is included as a fused multicyclic crosslinking agent and is considered to contain two polymerizable norbornene-type double bonds.



wherein Y represents a methylene (-CH₂-) group and m independently represents an integer from 0 to 5, and when m is 0, Y represents a single bond. Representative monomers under the forgoing formulae are set forth below.

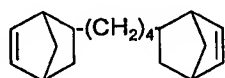


A linked multicyclic crosslinking agent is illustrated generically in Structure VIII below.

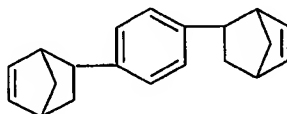


wherein "a" independently represents a single or double bond, m independently is an integer from 0 to 5, R^9 is a divalent radical selected from divalent hydrocarbyl radicals, divalent ether radicals and divalent silyl radicals, and n is equal to 0 or 1. By divalent is meant that a free valence at each terminal end of the radical is attached to a norbornene-type moiety. In one embodiment, the divalent hydrocarbyl radicals are alkylene radicals and divalent aromatic radicals. The alkylene radicals are represented by the formula $-(C_dH_{2d})-$ where d represents the number of carbon atoms in the alkylene chain and is an integer from 1 to 10. The alkylene radicals are, in one embodiment, selected from linear or branched (C_1 - C_{10}) alkylene such as methylene, ethylene, propylene, butylene, pentylene, hexylene, heptylene, octylene, nonylene, and decylene. When branched alkylene radicals are contemplated, it is to be understood that a hydrogen atom in the alkylene backbone is replaced with a linear or branched (C_1 to C_5) alkyl group.

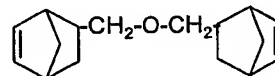
The divalent aromatic radicals are selected from divalent phenyl, and divalent naphthyl radicals. The divalent ether radicals are represented by the group $-R^{10}-O-R^{10}-$, wherein R^{10} independently is the same as R^9 . Examples of specific linked multicyclic crosslinking agents are represented as in Structures VIIIa to VIIIc as follows.



VIIIa

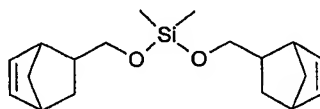


VIIIc

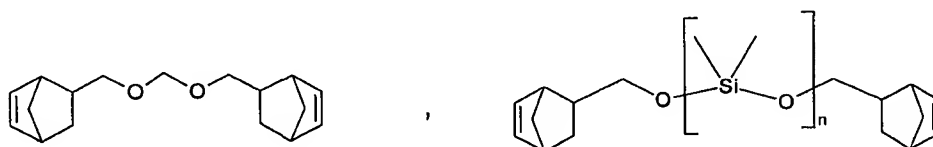


VIIIb

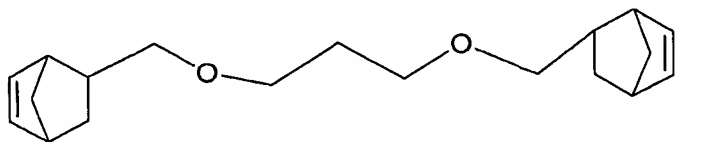
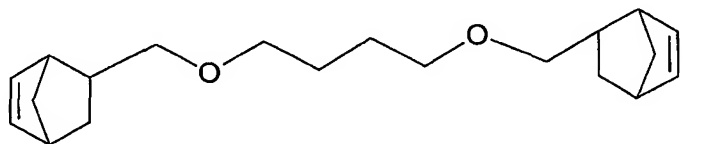
In one embodiment, the crosslinking agent is selected from those shown below:



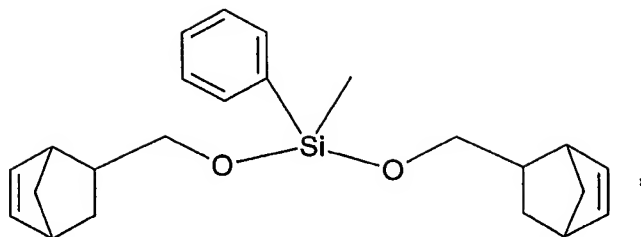
which is dimethyl bis[bicyclo[2.2.1]hept-2-ene-5-methoxy] silane (also referred to herein as dimethyl bis(norbornene methoxy) silane),



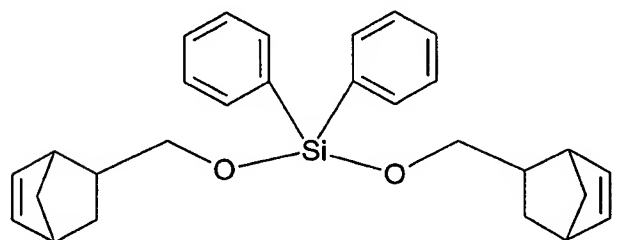
where n is 1 to 4,



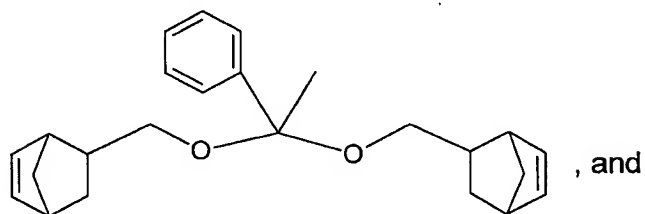
5



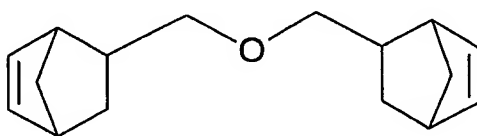
10



15

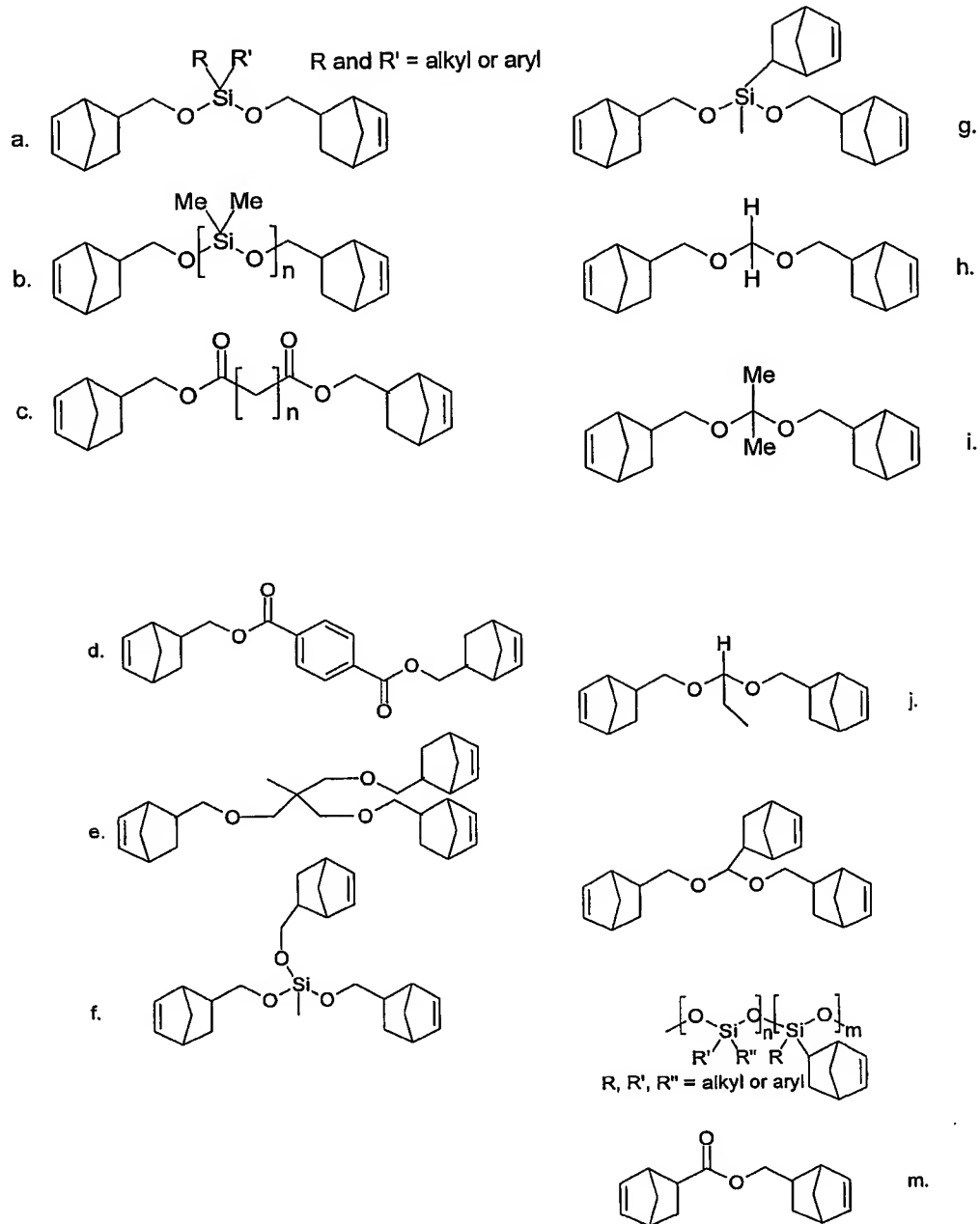


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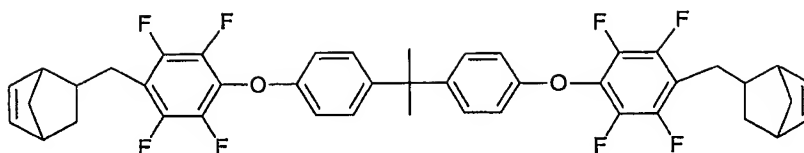


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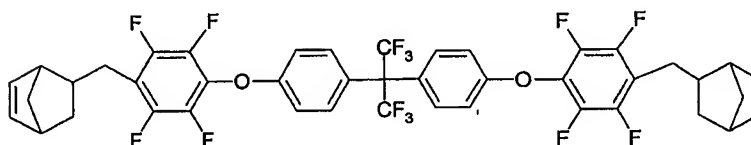
Some other types of norbornene-based crosslinking agents include, but are not limited to, those represented in formulae a-m below.



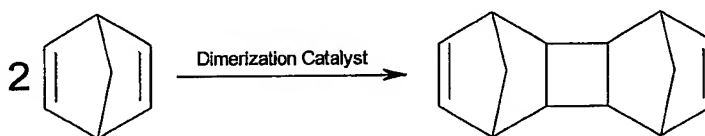
In another embodiment, fluorine-containing norbornene-based cross linkers are used. For example, in one embodiment one or more of the following fluorinated norbornene crosslinking agents can be utilized.

**F - Crosslinking Agent I**

and

**F - Crosslinking Agent II.**

Norbornadiene may be employed as a crosslinking agent in this invention. In another embodiment, higher homologs are utilized. Norbornadiene can be converted into higher homologs or Diels-Alder products using a variety of dimerization catalysts or heating it with cyclopentadiene. In the case of the crosslinking monomer norbornadiene dimer an alternative synthesis is employed in which norbornadiene is coupled catalytically to yield a mixture of isomers of norbornadiene dimer as shown below:

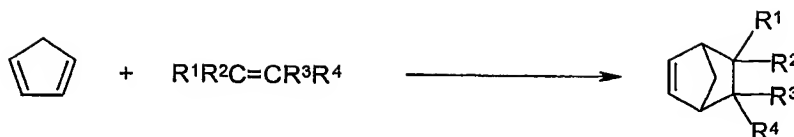


The dimerization of norbornadiene is easily achieved by numerous catalysts to yield a mixed composition of up to six isomers, i.e., Wu et al. U.S. Patent No. 5,545,790). In one embodiment, the isomers are the *exo-trans-exo*, *endo-trans-endo*, and *exo-trans-endo-1,4,4a,4b,5,8,8a,8b-octahydro-1,4:5,8-dimethanobiphenylene* ("norbornadiene dimer" or "[NBD]₂"). In another embodiment, the *exo-trans-exo* norbornadiene dimer is utilized as a crosslinking agent. Heating norbornadiene dimer with dicyclopentadiene or cyclopentadiene can produce higher oligomers of

norbornadiene dimer. Other crosslinking agents are prepared by the reaction of cyclopentadiene with olefins containing two or more reactive olefins, e.g., cyclooctadiene, 1,5-hexadiene, 1,7-octadiene, and tricycloheptatriene.

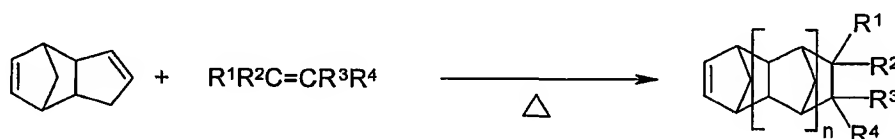
In one embodiment, the crosslinkable monomers are those containing two reactive norbornene type moieties (containing two polymerizable double bonds). In another embodiment, the monomer is 5,5'-(1,2-ethanediyl)bisbicyclo[2.2.1]hept-2-ene (NBCH₂CH₂NB) prepared by the reaction of 5-(3-butenyl)bicyclo[2.2.1]hept-2-ene and cyclopentadiene via a Diels-Alder reaction. The higher homolog of 5-(3-butenyl)bicyclo[2.2.1]hept-2-ene is also a co-monomer of choice, i.e., 2-(3-butenyl)-1,2,3,4,4a,5,8,8a-octahydro-1,4:5,8-dimethanonaphthalene. Similarly, 1,4,4a,5,6,6a,7,10,10a,11,12,12a-dodecahydro-1,4:7,10-dimethanodibenzo[a,e]cyclooctene is prepared in the Diels Alder reaction between 1,4,4a,5,6,9,10,10a-octahydro-1,4-methanobenzocyclooctene and cyclopentadiene. The higher homolog of between 1,4,4a,5,6,9,10,10a-octahydro-1,4-methanobenzocyclooctene is also a comonomer of choice, i.e., 1,4,4a,5,5a,6,7,10,11,11a,12,12a-dodecahydro-1,4:5,12-dimethanocycloocta[b]naphthalene. The symmetric and asymmetric trimers of cyclopentadiene are also useful crosslinking reagents, i.e., 4,4a,4b,5,8,8a,9,9a-octahydro-1,4:5,8-dimethano-1H-fluorene and 3a,4,4a,5,8,8a,9,9a-octahydro-4,9:5,8-dimethano-1H-benz[f]indene, respectively. In yet another embodiment, the monomer is obtained from the reaction of cyclopentadiene and norbornadiene, i.e., 1,4,4a,5,8,8a-hexahydro-1,4:5,8-dimethanonaphthalene. Divinylbenzene and excess cyclopentadiene forms the symmetric crosslinking agent 5,5'-(1,4-phenylene)bisbicyclo[2.2.1]hept-2-ene.

An economical route for the preparation of hydrocarbyl substituted and functionally substituted norbornene monomers relies on the Diels-Alder addition reaction in which CPD or substituted CPD is reacted with a suitable dienophile at elevated temperatures to form the substituted norbornene-type adduct generally shown by the following reaction scheme:

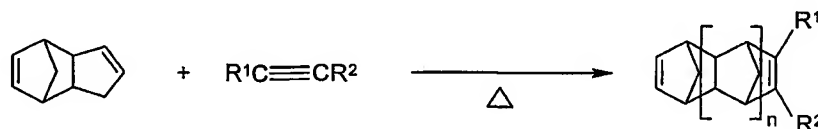
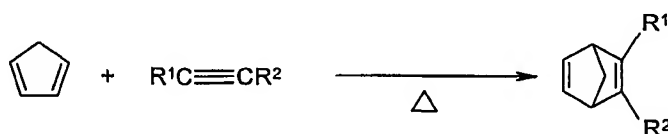


5 wherein R^1 to R^4 independently represent hydrogen, hydrocarbyl, and/or a functional group as previously described.

Other norbornene type adducts can be prepared by the thermal pyrolysis of dicyclopentadiene (DCPD) in the presence of a suitable dienophile. The reaction proceeds by the initial pyrolysis of DCPD to CPD followed by the Diels-Alder addition of CPD and the dienophile to give the adducts shown below:

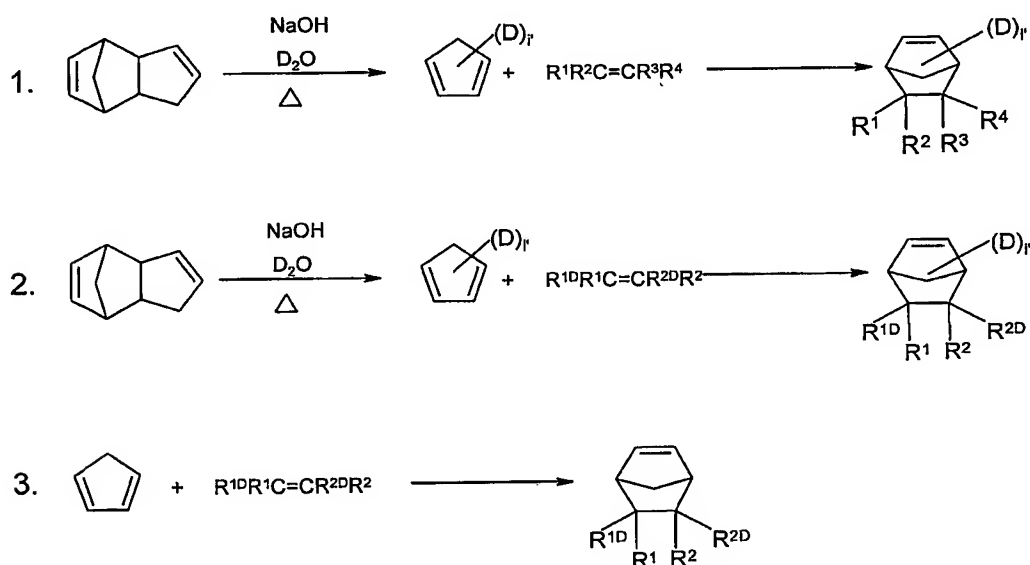


15 wherein n represents the number of cyclic units in the monomer and R^1 to R^4 independently represent hydrogen, hydrocarbyl, and/or a functional group as previously defined. Norbornadiene and higher Diels-Alder adducts thereof similarly can be prepared by the thermal reaction of CPD and DCPD in the presence of an acetylenic reactant as shown below.



25 wherein n , R^1 and R^2 are as defined above.

Deuterium enriched norbornene-type monomers can be prepared by heating DCPD in the presence of D_2O and a base such as NaOH to yield deuterated CPD which in turn can be reacted with a dienophile (Eq. 1) or a deuterated dienophile (Eq. 2) to give the respective deuterated norbornene containing a pendant deuterated hydrocarbyl substituent or a pendant hydrocarbyl substituent. In another embodiment non-deuterated CPD can be reacted with a deuterium enriched dienophile to yield norbornene containing a deuterium enriched hydrocarbyl pendant group (Eq. 3).



In Eq. 1 and Eq. 2 above, R^1 to R^4 , R^{1D} and R^{2D} are as previously defined, and i' is an integer ranging from 1 to 6.

Examples of polymerizable norbornene-type monomers include but are not limited to norbornene (bicyclo[2.2.1]hept-2-ene), 5-ethylidenenorbornene, dicyclopentadiene, tricyclo[5.2.1.0^{2,6}]deca-8-ene, 5-methoxycarbonylbicyclo[2.2.1]hept-2-ene,

- 5-methylbicyclo[2.2.1]hept-2-ene-5-carboxylic acid,
5-methylbicyclo[2.2.1]hept-2-ene,
5-ethylbicyclo[2.2.1]hept-2-ene,
5-ethoxycarbonylbicyclo[2.2.1]hept-2-ene,
5 5-n-propoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-*i*-propoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-*n*-butoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-(2-methylpropoxy)carbonylbicyclo[2.2.1]hept-2-ene,
5-(1-methylpropoxy)carbonylbicyclo[2.2.1]hept-2-ene,
10 5-*t*-butoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-cyclohexyloxycarbonylbicyclo[2.2.1]hept-2-ene,
5-(4'-*t*-butylcyclohexyloxy)carbonylbicyclo[2.2.1]hept-2-ene,
5-phenoxybicyclo[2.2.1]hept-2-ene,
5-tetrahydrofuranlyloxycarbonylbicyclo[2.2.1]hept-2-ene,
15 5-tetrahydropyranlyloxycarbonylbicyclo[2.2.1]hept-2-ene,
bicyclo[2.2.1]hept-2-ene-5-carboxylic acid,
5-acetyloxybicyclo[2.2.1]hept-2-ene,
5-methyl-5-methoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-ethoxycarbonylbicyclo[2.2.1]hept-2-ene,
20 5-methyl-5-n-propoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-*i*-propoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-*n*-butoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-(2-methylpropoxy)carbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-(1-methylpropoxy)carbonylbicyclo[2.2.1]hept-2-ene,
25 5-methyl-5-*t*-butoxycarbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-cyclohexyloxycarbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-(4'-*t*-butylcyclohexyloxy)carbonylbicyclo[2.2.1]hept-2-ene,
5-methyl-5-phenoxybicyclo[2.2.1]hept-2-ene,
5-methyl-5-tetrahydrofuranlyloxycarbonylbicyclo[2.2.1]hept-2-ene,
30 5-methyl-5-tetrahydropyranlyloxycarbonylbicyclo[2.2.1]hept-2-ene,

- 5-methyl-5-acetyloxybicyclo[2.2.1]hept-2-ene,
 5-methyl-5-cyanobicyclo[2.2.1]hept-2-ene,
 5,6-di(methoxycarbonyl)bicyclo[2.2.1]hept-2-ene,
 5,6-di(ethoxycarbonyl)bicyclo[2.2.1]hept-2-ene,
 5 5,6-di(*n*-propoxycarbonyl)bicyclo[2.2.1]hept-2-ene,
 5,6-di(*i*-propoxycarbonyl)bicyclo[2.2.1]hept-2-ene,
 5,6-di(*n*-butoxycarbonyl)bicyclo[2.2.1]hept-2-ene,
 5,6-di(*t*-butoxycarbonyl)bicyclo[2.2.1]hept-2-ene,
 5,6-di(phenoxy carbonyl)bicyclo[2.2.1]hept-2-ene,
 10 5,6-di(tetrahydrofuranyloxycarbonyl)bicyclo[2.2.1]hept-2-ene,
 5,6-di(tetrahydropyranyloxycarbonyl)bicyclo[2.2.1]hept-2-ene, and
 5,6-dicarboxyanhydridebicyclo[2.2.1]hept-2-ene,
 8-methoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-ethoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 15 8-*n*-propoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-*i*-propoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-*n*-butoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-(2-methylpropoxy)carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-(1-methylpropoxy)carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 20 8-*t*-butoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-cyclohexyloxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-(4'-*t*-butylcyclohexyloxy)carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-phenoxy carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-tetrahydrofuranyloxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]-3-dodecene,
 25 8-tetrahydropyranyloxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-acetyloxytetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-methoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-ethoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-*n*-propoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 30 8-methyl-8-*i*-propoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,

- 8-methyl-8-*n*-butoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-(2-methylpropoxy)carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-(1-methylpropoxy)carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-*t*-butoxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 5 8-methyl-8-cyclohexyloxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-(4'-*t*-butylcyclohexyloxy)carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-phenoxy carbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-tetrahydrofuran yloxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]-3-dodecene,
 8-methyl-8-tetrahydropyran yloxycarbonyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]-3-dodecene,
 10 8-methyl-8-acetyloxytetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-cyanotetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-di(methoxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-di(ethoxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-di(*n*-propoxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 15 8,9-di(*i*-propoxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-di(*n*-butoxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-di(*t*-butoxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-di(cyclohexyloxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-di(phenoxy carbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 20 8,9-di(tetrahydrofuran yloxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]-3-dodecene,
 8,9-di(tetrahydropyran yloxycarbonyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]-3-dodecene, 8,9-
 dicarboxyanhydridetetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene-8-carboxylic acid,
 25 8-methyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene-8-carboxylic acid,
 8-methyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-ethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-fluorotetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-fluoromethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 30 8-difluoromethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,

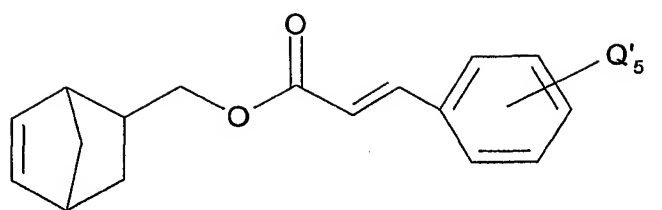
- 8-trifluoromethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-pentafluoroethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,8-difluorotetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-difluorotetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 5 8,8-bis(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-bis(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-trifluoromethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,8,9-trifluorotetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,8,9-tris(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 10 8,8,9,9-tetrafluorotetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,8,9,9-tetrakis(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,8-difluoro-9,9-bis(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-difluoro-8,9-bis(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,8,9-trifluoro-9-trifluoromethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 15 8,8,9-trifluoro-9-trifluoromethoxytetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,8,9-trifluoro-9-pentafluoropropoxytetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-fluoro-8-pentafluoroethyl-9,9-bis(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8,9-difluoro-8-heptafluoroisopropyl-9-trifluoromethyltetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-chloro-8,9,9-trifluorotetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 20 8,9-dichloro-8,9-bis(trifluoromethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-(2,2,2-trifluorocarboxyethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 8-methyl-8-(2,2,2-trifluorocarboxyethyl)tetracyclo[4.4.0.1^{2,5}.1^{7,10}]dodec-3-ene,
 tricyclo[4.4.0.1^{2,5}]undeca-3-ene,
 tricyclo[6.2.1.0^{1,8}]undeca-9-ene,
 25 tetracyclo[4.4.0..1^{2,5}.1^{7,10}.0^{1,6}]dodec-3-ene,
 8-methyltetracyclo[4.4.0.1^{2,5}.1^{7,10}.0^{1,6}]dodec-3-ene,
 8-ethylidenetetracyclo[4.4.0.1^{2,5}.1^{7,12}]dodec-3-ene,
 8-ethylidenetetracyclo[4.4.0.1^{2,5}.1^{7,10}.0^{1,6}]dodec-3-ene,
 pentacyclo[6.5.1.1^{3,6}.0^{2,7}.0^{9,13}]pentadeca-4-ene,
 30 pentacyclo[7.4.0.1^{2,5}.1^{9,12}.0^{8,13}]pentadeca-3-ene,

5-(n-hexyl)-bicyclo[2.2.1]hept-2-ene,
 5-(triethoxysilyl)bicyclo[2.2.1]hept-2-ene, and
 bicyclo[2.2.1]hept-2-ene-5-methoxy diphenyl methyl silane (also referred to herein as
 diphenyl methyl (norbornene methoxy) silane).

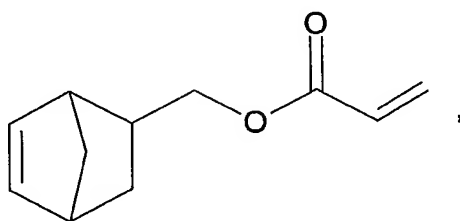
5 Examples of polymerizable norbornene-type monomers include but are not
 limited to, norbornene (bicyclo[2.2.1]hept-2-ene), 5-methyl-2-norbornene,
 ethylnorbornene, propylnorbornene, isopropylnorbornene, butylnorbornene,
 isobutylnorbornene, pentylnorbornene, hexylnorbornene, heptylnorbornene,
 octylnorbornene, decylnorbornene, dodecylnorbornene, octadecylnorbornene,
 10 trimethoxysilylnorbornene, butoxynorbornene, *p*-tolylnorbornene, methylenediphenyl
 norbornene, phenylnorbornene, ethylenediphenylnorbornene, vinylnorbornene,
 exo-dicyclopentadiene, endo-dicyclopentadiene, tetracyclododecene,
 methyltetracyclododecene, dimethyltetracyclododecene, ethyltetracyclododecene,
 ethylenediphenyl tetracyclododecene, phenyltetracyclododecene, tetramers of
 15 cyclopentadiene, propenylnorbornene, 5,8-methylene-5a,8a-dihydrofluorene,
 cyclohexenylnorbornene, dimethanohexahydronaphthalene,
 endo,exo-5,6-dimethoxynorbornene, endo,endo-5,6-dimethoxynorbornene,
 2,3-dimethoxynorbornadiene, 5,6-bis(chloromethyl)bicyclo[2.2.1]hept-2-ene,
 5-tris(ethoxy)silylnorbornene, 2-dimethylsilylbicyclo[2.2.1]hepta-2,5-diene,
 20 2,3-bistrifluoromethylbicyclo[2.2.1]hepta-2,5-diene,
 5-fluoro-5-pentafluoroethyl-6,6-bis(trifluoromethyl)bicyclo[2.2.1]hept-2-ene,
 5,6-difluoro-5-heptafluoroisopropyl-6-trifluoromethylbicyclo[2.2.1]hept-2-ene,
 2,3,3,4,4,5,5,6-octafluorotricyclo[5.2.1.0]dec-8-ene, and
 5-trifluoromethylbicyclo[2.2.1]hept-2-ene, 5-a-naphthyl-2-norbornene, 5,5-dimethyl-2-
 25 norbornene, 1,4,4a,9,9a,10-hexahydro-9,10[1',2']-benzeno-1,4-methanoanthracene,
 indanylnorbornene (i.e., 1,4,4,9-tetrahydro-1,4-methanofluorene, the reaction
 product of CPD and indene), 6,7,10,10-tetrahydro-7,10-methanofluoranthene (i.e.,
 the reaction product of CPD with acenaphthalene),
 1,4,4,9,9,10-hexahydro-9,10[1',2']-benzeno-1,4-methanoanthracene, endo,endo-5,6-
 30 dimethyl-2-norbornene, endo,exo-5,6-dimethyl-2-norbornene, exo,exo-5,6-dimethyl-

2-norbornene, 1,4,4,5,6,9,10,13,14,14-decahydro-1,4-methanobenzocyclododecene (i.e., reaction product of CPD and 1,5,9-cyclododecatriene), 2,3,3,4,7,7-hexahydro-4,7-methano-1H-indene (i.e., reaction product of CPD and cyclopentene), 1,4,4,5,6,7,8,8-octahydro-1,4-methanonaphthalene (i.e., reaction product of CPD and cyclohexene), 1,4,4,5,6,7,8,9,10,10-decahydro-1,4-methanobenzocyclooctene (i.e., reaction product of CPD and cyclooctene), and 1,2,3,3,3,4,7,7,8,8,decahydro-4,7-methanocyclopent[a]indene.

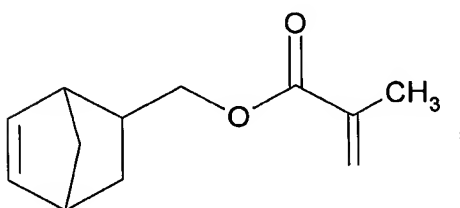
In another embodiment of the invention the polymer can be crosslinked during a post polymerization curing step (latent crosslinking). In this embodiment a norbornene-type monomer containing a pendant post crosslinkable functional group is copolymerized into the polycyclic backbone whereupon the functional group is subsequently crosslinked via well known techniques. By post crosslinkable functional group is meant that the functional group is inert to the initial polymerization reaction but is receptive to subsequent chemical reactions to effect the crosslinking of adjacent polymer chains. Suitable post crosslinkable monomers are set forth under Structure VII wherein at least one of R^1 to R^4 is selected from linear or branched C_2 - C_{10} alkenyl, C_4 - C_{10} cycloalkenyl, $-(CH_2)_nSi(OR^5)_3$, wherein n and R^5 are as defined above, R^1 and R^2 or R^3 and R^4 can be taken together to represent a C_1 - C_{10} alkylidenyl radical, fused cyclic groups wherein R^1 and R^4 taken together with the two ring carbon atoms to which they are attached form an unsaturated C_4 to C_8 ring. In one embodiment, post crosslinkable alkenyl functional groups include vinyl, butenyl, and cyclohexyl. In one embodiment, alkylidenyl groups include methylidenyl and ethylidenyl substituents. In one embodiment, alkoxyisilyl groups include trimethoxysilyl and triethoxysilyl moieties. In one embodiment, crosslinking agents containing fused multicyclic ring systems include dicyclopentadiene (DCPD) and unsymmetrical trimer of cyclopentadiene (CPD). Some exemplary latent crosslinking agents include, but are not limited to, the formulae shown below:



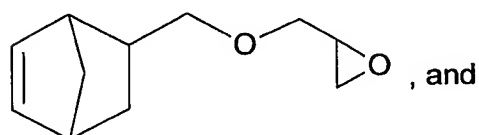
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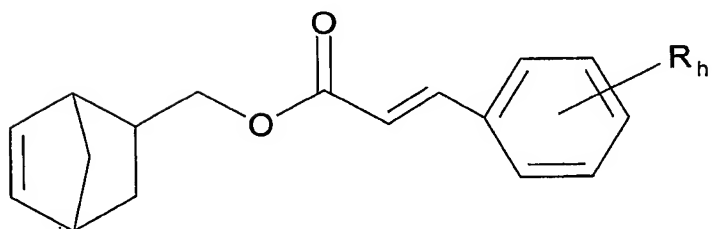
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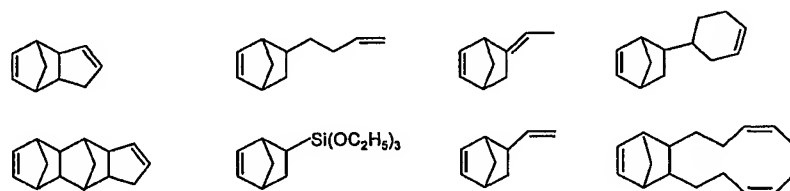
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where R_h represents a non-halogenated, halogenated or perhalogenated group such as $C_nQ''_{2n+1}$, n is an integer from 1 to 10, and Q'' represents a hydrogen or a halogen (e.g., Br, Cl, or F).

The latent crosslinkable pendant groups can be reacted via a variety of chemistries known to initiate the reaction of the various functional groups. For example, the alkenyl, cycloalkenyl, and alkylidenyl groups set forth under the definition R¹ to R⁵ of Structure VII above can be crosslinked via a free radical mechanism. The alkoxysilyl groups can be crosslinked via a cationic reaction mechanism. Representative monomers that contain post crosslinkable functional groups are represented below.



In the latent crosslinking embodiment of the invention the crosslinking reaction step can be induced by a free radical initiator. Suitable initiators are those that can be activated thermally or photochemically. The initiator can be added to the reaction medium and the polymerization of the monomer mixture is allowed to proceed to completion. If the latent initiator is present during polymerization, then a key consideration is that the radical generating compound employed be stable (does not decompose) at the polymerization temperature of the monomeric reaction medium. Alternatively, the latent initiator can be added to a solution of the polymer in an appropriate solvent after the polymerization has been completed. When utilizing thermally activated free radical generators or embodiments utilizing photo-acid generators, latent crosslinking is induced by exposing the polymer medium to temperatures above the decomposition temperature of the free radical generating compound. In embodiments utilizing photoinitiated free radical generators, latent crosslinking is induced by exposing the polymer medium to a radiation source such as e-beam and UV radiation. Suitable free radical generator compounds (crosslinking agents) include the organic peroxides and aliphatic azo compounds. The aliphatic azo compounds are suitable initiators for the thermal and

photochemical activated crosslinking embodiments of the invention, while the organic peroxides are suitable for use in as thermally activated initiators only. The amount of crosslinking agent employed ranges from about 0.005 part by weight to about 5.0 parts by weight based on 100 parts by weight of monomer in the reaction medium.

Suitable organic peroxide include, but are not limited to, dibenzoyl peroxide, di(2,4-dichlorobenzoyl) peroxide, diacetyl peroxide, diisobutyryl peroxide, dilauroyl peroxide, *t*-butylperbenzoate, *t*-butylperacetate, 2,5-di(benzoylperoxy)-1,2-dimethylhexane, di-*t*-butyl diperoxyazelaate, *t*-butyl peroxy-2-ethylhexanoate, *t*-amyl peroctoate, 2,5-di(2-ethylhexanoylperoxy)-2,5-dimethylhexane, *t*-butylperoxyneodecanoate, ethyl 3,3-di(*t*-butylperoxy)butyrate, 2,2-di(*t*-butylperoxy)butane, 1,1-di(*t*-butylperoxy)cyclohexane, 1,1-di(*t*-butylperoxy)-3,3,5-trimethylcyclohexane, 2,5-di(*t*-butylperoxy)-2,5-dimethylhex-3-yne, di-*t*-butyl peroxide, 2,5-di(*t*-butylperoxy)-2,5-dimethylhexane, dicumyl peroxide, *n*-propyl peroxydicarbonate, *i*-propyl peroxydicarbonate, cyclohexyl peroxydicarbonate, and acetyl peroxydicarbonate.

Suitable azo compounds include, but are not limited to, 2,2'-azobis[2,4-dimethyl]pentane, 2-(*t*-butylazo)-4-methoxy-2,4-dimethylpentanenitrile, 2,2'-azobis(*i*-butyronitrile), 2-(*t*-butylazo)-2,4-dimethylpentanenitrile, 2-(*t*-butylazo)-*i*-butyronitrile, 2-(*t*-butylazo)-2-methylbutanenitrile, 1,1-azobis-cyclohexanecarbonitrile, 1-(*t*-amylazo)cyclohexanecarbonitrile, and 1-(*t*-butylazo)cyclohexanecarbonitrile.

Suitable photo-initiators for free-radical crosslinking include, but are not limited to, benzoin ethyl ether, diphenyl (2,4,6-trimethyl benzoyl) phosphine oxide, 4,4'-bis(diethylamino) benzophenone, 4,4'-bis(dimethylamino) benzophenone and 4-(dimethylamino) benzophenone.

Suitable photo-initiators for cationic crosslinking include, but are not limited to, onium salts, halogenated organic compounds, quinone diazide compounds, α,α -bis(sulfonyl)diazomethane compounds, α -carbonyl- α -sulfonyl diazomethane compounds, sulfone compounds, organic acid ester compounds, organic acid amide compounds, organic acid imide compounds, etc. Actual examples of onium salts are

unsubstituted or symmetrically or asymmetrically substituted alkyl groups, alkenyl groups, aralkyl groups, aromatic groups, diazonium salts with heterocyclic groups, ammonium salts, iodonium salts, sulfonium salts, phosphonium salts, arsonium salts, oxonium salts, etc. There are no restrictions to counter anions of these onium salts as long as they are compounds that can form counter anions. Examples are boric acid, arsenic acid, phosphoric acid, antimonic acid, sulfonic acid, carboxylic acid, and their halides. There are no special restrictions to the halogenated organic compound as long as they are halides or organic compounds, and a variety of conventional compounds can be employed. Actual examples include halogen-containing oxadiazole compounds, halogen-containing triazine compounds, halogen-containing acetophenone compounds, halogen-containing benzophenone compounds, halogen-containing sulfoxide compounds, halogen-containing sulfone compounds, halogen-containing thiazole compounds, halogen-containing oxazole compounds, halogen-containing triazole compounds, halogen-containing 2-pyrone compounds, halogen-containing aliphatic hydrocarbon compounds, halogen-containing aromatic compounds, other halogen-containing heterocyclic compounds, sulfonyl halide compounds, etc. Actual examples of o-quinone diazide compounds are 1,2-benzoquinone diazido-4-sulfonic acid ester, 1,2-naphthoquinone diazido-4-sulfonic acid ester, 1,2-naphthoquinone diazido-5-sulfonic acid ester, 1,2-naphthoquinone diazido-6-sulfonic acid ester, 2,1-naphthoquinone diazido-4-sulfonic acid ester, 2,1-naphthoquinone diazido-5-sulfonic acid ester, 2,1-naphthoquinone diazido-6-sulfonic acid ester, other quinone diazido derivative sulfonic acid esters, 1,2-benzoquinone diazido-4-sulfonic acid chloride, 1,2-naphthoquinone diazido-4-sulfonic acid chloride, 1,2-naphthoquinone diazido-5-sulfonic acid chloride, 1,2-naphthoquinone diazido-6-sulfonic acid chloride, 2,1-naphthoquinone diazido-4-sulfonic acid chloride, 2,1-naphthoquinone diazido-5-sulfonic acid chloride, 2,1-naphthoquinone diazido-6-sulfonic acid chloride, and other quinone diazide derivative sulfonic acid chlorides. Examples of α,α -bis(sulfonyl)diazomethane compounds are unsubstituted or symmetrically or asymmetrically substituted α,α -bis(sulfonyl)diazomethane with alkyl groups, alkenyl groups, aralkyl groups, aromatic groups, or heterocyclic groups, etc.

Actual examples of α -carbonyl- α -sulfonyl diazomethane compounds are unsubstituted or symmetrically or asymmetrically substituted α -carbonyl- α -sulfonyl diazomethane with alkyl groups, alkenyl groups, aralkyl groups, aromatic groups, or heterocyclic groups. Actual examples of sulfone compounds are non-substituted or symmetrically or asymmetrically substituted sulfone compounds or disulfone compounds with alkyl groups, alkenyl groups, aralkyl groups, aromatic groups or heterocyclic groups. Actual examples of organic acid esters are unsubstituted or symmetrically or asymmetrically substituted carboxylic acid esters, sulfonic acid esters, etc., with alkyl groups, alkenyl groups, aralkyl groups, aromatic groups or heterocyclic groups. Actual examples of organic acid amide groups are unsubstituted or symmetrically or asymmetrically substituted carboxylic acid amides, sulfonic acid amides, etc., with alkyl groups, alkenyl groups, aralkyl groups, aromatic groups or heterocyclic groups. Actual examples of organic imides are unsubstituted or symmetrically or asymmetrically substituted carboxylic acid imides, sulfonic acid imides, etc., with alkyl groups, alkenyl groups, aralkyl groups, aromatic groups or heterocyclic groups. One or more of the photo-initiators can be utilized in the present invention.

When a latent initiator is present during polymerization or in the polymerization medium, the decomposition temperatures of the foregoing free radical generator compounds are well known in the art and can be selected on the basis of the polymerization temperatures employed in initial reaction. In other words the initiator compound must be stable at the polymerization temperatures so it is available for the post polymerization crosslinking reaction. As discussed above latent crosslinking is can be effected by thermal or photochemical means.

As discussed above, monomers containing trialkoxysilyl groups can be crosslinked by latent crosslinking in the presence of a cationic initiator agent. A polymerization stable cationic initiator can be can be thermally activated to induce the latent crosslinking of the silyl groups. Suitable cationic crosslinking initiators include, for example, dibutyltin dilaurate, dimethyltin dilaurate, and dioctyltin dilaurate.

The amount of multifunctional norbornene-type crosslinkable monomers and post crosslinkable monomers that are optionally present in the reaction mixture can range from about 0.1 mole percent to about 50 mole percent based on the total monomer in the monomer mixture to be reacted. In one embodiment, the amount of crosslinking agent ranges from about 1 mole percent to about 25 mole percent of the total monomer mixture. In another embodiment, the amount of crosslinking agent ranges from about 1 mole percent to about 10 mole percent of the total monomer mixture.

Monomer Polymerization

The monomers of the invention are polymerized in solution or in mass. The catalyst is added to the reaction medium containing the desired monomer(s) as a preformed single component catalyst or the catalyst can be formed *in situ* by admixing the pro-catalyst component, the Group 15 electron donor component, and the WCA salt activator component in the reaction medium. When the pro-catalyst is ligated with the Group 15 electron donor component, it is not necessary to employ the Group 15 electron donor as a separate component. In one *in situ* embodiment the ligated pro-catalyst component (e.g., containing desired ligand group(s)) is admixed with the WCA salt activator component in the reaction medium. In another *in situ* embodiment a pro-catalyst component with or without ligands is admixed with a desired ligand containing component(s) and the WCA salt activator component in the reaction medium. The pro-catalyst components are generically exemplified in the preformed catalyst preparation equations (1) to (4) set forth above. In one embodiment, the molar ratio of pro-catalyst (based on the Group 10 metal) : Group 15 electron donor component : WCA salt is 1:1-10:1-100. In another embodiment, the ratio is 1:1-5:1-20. In yet another embodiment, the ratio is 1:1-2:1-5. In embodiments of the invention where the pro-catalyst is ligated with a Group 15 electron donor ligand and/or a labile neutral electron donor ligand, the molar ratio of pro-catalyst (based on the metal content) to WCA salt is 1:1-100. In another

embodiment, the ratio is 1:1-20. In yet another embodiment, the ratio is 1:1-5. The order of addition of the various catalyst components to the reaction medium is not important.

The polymers prepared by the process of the invention are addition polymers of polycycloolefinic repeating units linked through 2,3-enchainment. The repeating units are polymerized from a polycycloolefin monomer or combination of polycycloolefin monomers that contain at least one norbornene-type moiety as described herein.

Solution Process

In the solution process the polymerization reaction can be carried out by adding a solution of the preformed catalyst or individual catalyst components to a solution of the cycloolefin monomer or mixtures of monomers to be polymerized. The amount of monomer in solvent, in one embodiment, ranges from 10 to 50 weight percent. In another embodiment, the amount of monomer in solvent ranges from 20 to 30 weight percent. After the single component catalyst or catalyst components are added to the monomer solution, the reaction medium is agitated (e.g., stirred) to ensure complete mixing of catalyst and monomer components.

The polymerization reaction temperatures can range from about 0°C to about 150°C. In another embodiment, the polymerization reaction temperatures can range from about 10°C to about 100°C. In yet another embodiment, the polymerization reaction temperatures can range from about 20°C to about 80°C.

Examples of solvents for the polymerization reaction include but are not limited to alkane and cycloalkane solvents such as pentane, hexane, heptane, and cyclohexane; halogenated alkane solvents such as dichloromethane, chloroform, carbon tetrachloride, ethylchloride, 1,1-dichloroethane, 1,2-dichloroethane, 1-chloropropane, 2-chloropropane, 1-chlorobutane, 2-chlorobutane, 1-chloro-2-methylpropane, and 1-chloropentane; aromatic solvents such as benzene, xylene, toluene, mesitylene, chlorobenzene, anisole and o-dichlorobenzene, Freon® 112 halocarbon solvent, water; or mixtures thereof. In one embodiment, the solvent is selected from cyclohexane, toluene, mesitylene,

dichloromethane, 1,2-dichloroethane, and water.

When an aqueous polymerization medium is desired, the Group 15 electron donor ligand or component may be chosen from the water soluble phosphines set forth above, although this is not a strict requirement. The polymerization reaction can be conducted in suspension or emulsion. In suspension, the monomers are suspended in an aqueous medium containing a suspension agent selected from one or more water soluble substances such as, for example, polyvinyl alcohol, cellulose ether, partially hydrolyzed polyvinyl acetate, or gelatin and then carrying out the reaction in the presence of the catalyst system of the invention.

The emulsion polymerization can in general be carried out by emulsifying the monomers in water or a mixed solvent of water and a water-miscible organic solvent (such as methanol, or ethanol). In one embodiment, this is done in the presence of at least one emulsifying agent. Then, the emulsion polymerization is carried out in the presence of the catalyst as discussed herein. Emulsifying agents include, for example, mixed acid soaps containing fatty and rosin acids, alkyl sulfonate soaps and soaps of oligomeric naphthalene sulfonates.

Mass Process

In the mass polymerization process according to the invention at least one monomer component (e.g., at least one cycloolefinic monomer) is polymerized using a catalyst system. In another embodiment, the mass polymerization process according to the invention polymerizes at least one monomer crosslinking component (e.g., at least one cycloolefinic crosslinking monomer) using a catalyst system. In yet another embodiment, the mass polymerization process according to the invention is a two component monomer system (i.e. at least two cycloolefinic monomers of which none, one or two can be a crosslinking monomer) which is polymerized using a catalyst system. In still another embodiment, the mass polymerization process according to the invention is at least a three component monomer system (i.e. at least two cycloolefinic monomers of which at least one of which is a crosslinking monomer) which is polymerized using a catalyst system.

The term mass polymerization refers to a polymerization reaction which is

generally carried out in the substantial absence of a solvent. In some cases, however, a small proportion of solvent is present in the reaction medium. Small amounts of solvent can be conveyed to the reaction medium via the introduction of the catalyst system components which are in some cases dissolved in solvent.

5 Solvents also can be employed in the reaction medium to reduce the viscosity of the polymer at the termination of the polymerization reaction to facilitate the subsequent use and processing of the polymer. The amount of solvent that can be present in the reaction medium ranges from 0 to about 20 percent based on the weight of the monomer(s) present in the reaction mixture. In another embodiment, the amount of solvent that can be present in the reaction medium ranges from 0 to about 10 percent based on the weight of the monomer(s) present in the reaction mixture. In still another embodiment, the amount of solvent present that can be in the reaction medium ranges from 0 to about 1 percent, based on the weight of the monomer(s) present in the reaction mixture. In one embodiment, the solvent or solvents utilized are chosen such that the catalyst system components dissolve therein. Examples of solvents include, but are not limited to, alkane and cycloalkane solvents such as pentane, hexane, heptane, and cyclohexane; halogenated alkane solvents such as dichloromethane, chloroform, carbon tetrachloride, ethylchloride, 1,1-dichloroethane, 1,2-dichloroethane, 1-chloropropane, 2-chloropropane, 1-chlorobutane, 2-chlorobutane, 1-chloro-2-methylpropane, and 1-chloropentane; esters such as ethylacetate, *i*-amylacetate; ethers such as THF and diethylether; aromatic solvents such as benzene, xylene, toluene, mesitylene, chlorobenzene, anisole and *o*-dichlorobenzene; and halocarbon solvents such as Freon® 112; and mixtures thereof. In one embodiment, the solvent or solvents is/are selected from benzene, fluorobenzene, *o*-difluorobenzene, *p*-difluorobenzene, pentafluorobenzene, hexafluorobenzene, *o*-dichlorobenzene, chlorobenzene, toluene, *o*-, *m*-, and *p*-xylenes, mesitylene, cyclohexane, ethylacetate, THF, and dichloromethane.

A ligated pro-catalyst containing a Group 15 electron donor ligand is prepared in solvent and then added to the desired monomer or mixture of monomers containing the dissolved WCA salt activator. The reaction mixture is

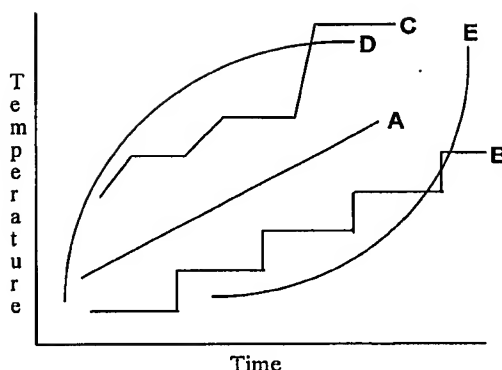
mixed and the reaction is permitted to proceed from about 1 minute to about 2 hours. The reaction mixture can be optionally heated at a temperature ranging from about 20 °C to about 200 °C. The polymerization temperature is not specifically limited. In one embodiment, the polymerization temperature is in the range of 20 °C to 120 °C. In another embodiment, the polymerization temperature is in the range of 20 °C to 90 °C.

The polymerization reaction can be carried out under an inert atmosphere such as nitrogen or argon. Advantageously, however, it has been found that the catalyst system components of the invention are moisture and oxygen insensitive, allowing for less stringent handling and processing conditions. Following the initial polymerization reaction a polymer cement is obtained. The cement can be applied to a desired substrate or conveyed into a mold and post cured to complete the polymerization reaction.

Without wishing to be bound by theory of invention it is believed that post curing is desirable from the standpoint of monomer to polymer conversion. In a mass process the monomer is essentially the diluent for the catalyst system components. As monomer is converted to polymer a plateau is reached beyond which conversion of monomer to polymer can go no higher (vitrification). This conversion barrier results from the loss of reactant mobility as the reaction medium becomes converted to a polymeric matrix. Consequently, the catalyst system components and unconverted monomer become segregated and can not react. It is well known that diffusivity within a polymer decreases dramatically as the polymer passes from the rubbery state to the glassy state. It is believed that post curing at elevated temperatures increases the mobility of the reactants in the matrix allowing for the further conversion of monomer to polymer.

Post curing of the polymers of the present invention is, in one embodiment, conducted at elevated temperatures for a time period sufficient to reach a desired conversion of monomer to polymer. In one embodiment, the post curing cycle is conducted for about 1 to about 2 hours over a temperature range of from about 100 °C to about 300 °C. In another embodiment, the post curing cycle is conducted

for about 0.5 to about 4 hours at a over a temperature range of from about 100 °C to about 300 °C. In another embodiment, the post curing cycle is conducted for 1 to 2 hours over a temperature range of from about 125 °C to about 200 °C. In still another embodiment, the post curing cycle is conducted for 1 to 2 hours over a temperature range of from about 140 °C to about 180 °C. The cure cycle can be effected at a constant temperature or the temperature can be ramped, e.g., incrementally increasing the curing temperature from a desired minimum curing temperature to a desired maximum curing temperature over the desired curing cycle time range. In one embodiment (A) the temperature ramping can be effected by following a gradual increasing slope on a temperature vs. time plot from the desired minimum temperature to the desired maximum temperature in the cure cycle. In this embodiment when the maximum temperature is reached, the temperature maximum can optionally be held for a desired period of time until the desired cure state is attained. In an alternate embodiment (B) the temperature ramping can follow a stepwise curve on a temperature vs. time plot. In this embodiment the temperature ramping proceeds in step fashion from the desired minimum cure temperature to the desired maximum cure temperature in the cure cycle. In another embodiment (C) the post cure can be effected by combining post cure embodiments (A and B) wherein the cure cycle encompasses a combination of steps and slopes from the desired minimum cure temperature to the desired maximum cure temperature. In still another embodiment (D and E) the cure cycle can follow a curve from the desired minimum cure temperature to the desired maximum cure temperature. In embodiments A, B, and C it should be noted that the rise and run of the slope do not have to be constant between the minimum and maximum cure temperatures of the cure cycle. In other words the rise and run can vary when proceeding from the desired minimum to desired maximum cure temperatures The foregoing cure cycle temperature ramping curves are illustrated below.



Ramping of the temperature during the cure cycle is advantageous because it diminishes the potential for catalyst degradation and the volatilization of unconverted monomer.

In another embodiment, the polymerization and the post-curing are both conducted together. In one embodiment, the polymerization/post-cure is conducted for 1 to 2 hours at a temperature in the range of from about 20 °C to about 200 °C. In another embodiment, the polymerization/post cure is conducted for 1 to 2 hours at a temperature in the range of from about 125 °C to about 200 °C. In still another embodiment, the post curing cycle is conducted for 1 to 2 hours over a temperature range of from about 140 °C to about 180 °C.

Alternatively, the polymerization/post-cure can be conducted at more than one temperature (i.e. within a range of temperatures). For example, the polymerization/post-cure can be conducted over a range of temperatures similar to the ranges given immediately above. If the polymerization/post-cure is being conducted within a range of temperatures, the temperature at which the polymerization/post-cure is being conducted can be altered according to the discussion had above with regard to temperature ramping.

Optionally, additives may include, but are not limited to, those selected from pigments, dyes, non-linear optical dyes, erbium complexes, praseodymium complexes, neodymium complexes, plasticizers, lubricants, flame retardants, tackifiers, antioxidants (e.g., Irganox® 1010, 1076, 3114, or Cyanox® 1790), UV

stabilizers, masking agents, odor absorbing agents, crosslinking agents, synergists (e.g., Irgafos® 168, thiodipropionic acid dilauryl ester, or a combination of both), tougheners and impact modifiers, polymeric modifiers and viscosifiers and mixtures thereof (e.g., poly-iso-butylene, EPDM rubbers, siloxane oligomers and mixtures thereof), can be added by mixing one or more of them into the monomer medium .
5 before the polymerization reaction is initiated. The identity and relative amounts of such components are well known to those skilled in the art and need not be discussed in detail here.

The optional additives are employed to enhance the processing, appearance
10 and/or the physical properties of the polymer. For example, the additives can be utilized to enhance and modify *inter alia* the coefficient of thermal expansion, stiffness, impact strength, dielectric constant, solvent resistance, color, optical properties and odor of the polymer product. The viscosifiers are employed to modify the viscosity and shrinkage of the monomeric mixture before the polymerization
15 reaction is initiated. Suitable viscosity modifiers include elastomers and the norbornene-type polymers of the present invention. The viscosity modifiers can be dissolved in the polymerizable monomers of the invention to increase the viscosity of the monomer reaction mixture. As discussed above, crosslinking can be effected during the initial polymerization reaction of the monomer mixture or during a post
20 polymerization thermal or photochemical curing step.

In one embodiment, when a pro-catalyst is employed in the mass polymerization system of the invention, the molar ratio of monomer to pro-catalyst (based on metal content) to WCA salt activator ratios ranges from about
500,000:1:1 to about 5,000:1:20. In another embodiment, the molar ratio of
25 monomer to pro-catalyst (based on metal content) to WCA salt activator ratios ranges from about 250,000:1:5 to about 20,000:1:10. In yet another embodiment, the molar ratio of monomer to pro-catalyst (based on metal content) to WCA salt activator ratios ranges from about 200,000:1:20 to about 100,000:1:1.

Further information regarding the above can be found in International Patent Application Publication No. WO 00/20472 to The BFGoodrich Company, published on April 13, 2000, and International Patent Application Publication No. WO 00/34344 also to The BFGoodrich Company, published on June 15, 2000, both of which are hereby incorporated herein by reference in their entirety.

Optical Waveguide Formulations:

In one embodiment, the polymer compositions for use in the present invention have from about 100 to about 100,000 repeating units as defined above by one or more of Structures VII, VIIa and VIIb. In another embodiment, the polymer compositions for use in the present invention have from about 500 to about 50,000 repeating units as defined above by one or more of Structures VII, VIIa and VIIb. In yet another embodiment, the polymer compositions for use in the present invention have from about 1,000 to about 10,000 repeating units as defined above by one or more of Structures VII, VIIa and VIIb.

In one embodiment, a waveguide is formed using one of the methods disclosed below with at least two polyacrylate, polyimide, benzocyclobutene, cyclic olefin polymers, such that the core material and the clad material have a difference in their indices of refraction at 830 nm (Δn at 830 nm), core versus clad, of at least 0.00075 or more (or at least 0.05% when the clad refractive index is 1.5). That is, the refractive index of the polymer core layer is at least 0.05% greater than the refractive index of the at least one polymer cladding layer. If the waveguide is a three layer waveguide, the cladding layers (top cladding layer and sub-cladding layer) may be different polymers layers so long as both cladding layers have a refractive index which is at least 0.05% less than that of the polymer used to form the core layer.

In another embodiment, when the waveguide is to be formed from cyclic olefin monomers, both the core and cladding polymer layers of the optical waveguide of the present invention are formulated to include at least one cyclic olefin monomer (e.g., at least one norbornene-type monomers) and/or at least one

crosslinking monomer, at least one pro-catalyst (see the discussion of pro-catalysts above under the Catalyst Preparation heading), at least one co-catalyst (i.e., a WCA salt having a weakly coordinating ion, see above), and optionally one or more of the additives discussed above (see the discussion under the Mass Process heading).

5 Such a mixture is polymerized using the above-described mass polymerization process (see the discussion under the Mass Process heading) by either adding the pro-catalyst to a mixture containing the at least one cyclic olefin monomer, the co-catalyst, and any optional additives, or by adding the co-catalyst to a mixture containing the at least one cyclic olefin monomer, the pro-catalyst, and any
10 optional additives. In both these situations the active catalyst is generated *in situ*.

 In yet another embodiment, each of the clad and core formulations (which differ to the extent necessary to produce the required difference in their respective refractive indices) is formed from a 2-component system. That is, the clad formulation is produced from at least two components, Components A and B. On
15 the other hand, the core formulation is also produced from at least two components, Components C and D. Each of components A through D contain at least one norbornene-type monomer.

 In another embodiment, Components A and B are two substantially identical mixtures of the at least one norbornene-type monomer and/or at least one
20 crosslinking monomer. The difference between Components A and B generally arises from the inclusion of a pro-catalyst in Component A versus the inclusion of a co-catalyst in Component B. Additional differences between Component A and Component B may exist. For example, Component A may contain an optional additive not present in Component B, or vice versa.

25 In one embodiment, Component A comprises at least one norbornene-type monomer and/or at least one crosslinking monomer, at least one pro-catalyst and optionally an additive as discussed above (such as an antioxidant). Whereas, Component B comprises the same norbornene-type monomer(s), the same crosslinking agent(s), at least one co-catalyst, and optionally an additive (such as an
30 antioxidant) and/or a synergist. In this situation, polymerization is conducted using

the Mass Process polymerization method by mixing equal amounts of Components A and B, thereby generating the active polymerization catalyst *in situ*.

Alternatively, each of the clad and/or clad formulations may be a one part mixture in which at least one norbornene-type monomer and/or at least one crosslinking monomer, at least one co-catalyst, and any optional additives are present. To cause the polymerization reaction to occur a pro-catalyst is added to the above mixture(s). In another embodiment, each of the core and/or clad formulations may be a one part mixture in which at least one norbornene-type monomer and/or at least one crosslinking agent, at least one pro-catalyst, and any optional additives are present. To cause the polymerization reaction to occur a co-catalyst is added to the above mixture(s). Again it is noted, that generally the clad and core formulations differ with respect to the at least one norbornene-type monomer and/or at least one crosslinking monomer present therein. It is this difference, in one embodiment, that permits the formation of polymers having the necessary difference in their respective refractive indices.

In another embodiment, each of the clad and/or core formulations contain at least one norbornene-type crosslinking monomer (as discussed above), at least one co-catalyst and any optional additives as discussed above. To cause the polymerization reaction to occur a pro-catalyst is added to the above mixture(s).

Alternatively, the above mixture could be divided into two or more portions and the co-catalyst added to one portion while the pro-catalyst is added to another portion. In this instance, polymerization is accomplished by the combination of all of the portions.

In yet another embodiment, each of the core and/or clad formulation may be a one part mixture in which at least one norbornene-type crosslinking monomer, at least one pro-catalyst, and any optional additives are present. To cause the polymerization reaction to occur a co-catalyst is added to the above mixture(s). Again it is noted, that generally the clad and core formulations differ with respect to the at least one norbornene-type crosslinking monomer present therein. It is this difference, in one embodiment, that permits the formation of polymers having the

necessary difference in their respective refractive indices. Alternatively, the above mixture could be divided into two or more portions and the co-catalyst added to one portion while the pro-catalyst is added to another portion. In this instance, polymerization is accomplished by the combination of all of the portions.

Below are some exemplary clad and core formulations. It should be noted that these formations are exemplary in nature and are not meant to serve as an exhaustive list of the possible formulations for each of the clad and core. Rather, other clad and core formulations can be produced in view of the above disclosure so long as the refractive index of the polymer produced using the core formulation is at least 0.05% larger than that of the polymer produced using the clad formulation.

Exemplary Clad Formulations:

In one embodiment, the clad formulation contains: (1) one norbornene-type monomer containing a pendant C₄ to C₂₀ alkyl group, (2) one norbornene-type monomer containing a pendant C₁ to C₁₀ alkoxyethyl group, and (3) at least one crosslinking agent (as disclosed above). In addition to components (1), (2) and (3), the clad formulation also contains at least one pro-catalyst, at least one co-catalyst, and optionally an additive or additives as discussed above. As noted above, if components (1), (2) and (3) are all present in one mixture then either the pro-catalyst or the co-catalyst is held out of the mixture and added to the mixture at a later time.

Alternatively, components (1), (2) and (3) can be divided into two or more portions and the pro-catalyst added to one portion to form Component A (which can optionally include an additive or additives). To another portion of components (1), (2) and (3) is added the co-catalyst to form Component B (which can optionally include the same, different or additional additives as Component A). Polymerization is accomplished in this embodiment by combining Component A and Component B (along with any other portion of component (1), (2) and (3) not used to for Components A and B).

In one embodiment, component (3) is at least one crosslinking agent selected from dimethyl bis(norbornenemethoxy) silane, octamethyl 1,8-bis(norbornenemethoxy) tetrasiloxane, bis(norbornenemethyl)acetal or a fluorinated crosslinking agent (such as F-Crosslinking Agents I and II shown above).

5 Exemplary Core Formulations:

10 In one embodiment, the core formulation contains: (1) one norbornene-type monomer containing a pendant C₄ to C₂₀ alkyl group, (2) one norbornene-type monomer containing a pendant silane group with at least one C₆ to C₁₂ aryl group attached to the Si atom of the silane group, and (3) at least one crosslinking agent (as disclosed above). In addition to components (1), (2), and (3) the core formulation also contains at least one pro-catalyst, at least one co-catalyst, and optionally an antioxidant and/or a synergist. If components (1), (2) and (3) are all present in one mixture than either the pro-catalyst or the co-catalyst is held out of the mixture and added to the mixture at a later time.

15 Alternatively, components (1), (2) and (3) can be divided into two or more portions and the pro-catalyst added to one portion to form Component A (which can optionally include an additive such as an antioxidant). The other portion of components (1), (2) and (3) can be combined with the co-catalyst to form Component B (which can optionally include an additive such as an antioxidant and/or a synergist).

20 In one embodiment, component (3) is at least one crosslinking agent selected from dimethyl bis(norbornenemethoxy) silane, octamethyl 1,8-bis(norbornenemethoxy) tetrasiloxane, bis(norbornenemethyl)acetal or a fluorinated crosslinking agent (such as F-Crosslinking Agents I and II shown above).

25 In one embodiment, the molar ratio, stated in mole percent, of component (1):component (2):component (3) in either the clad or core formulation is 60-90:5-20:5-20. In another embodiment, the molar percent ratio of component (1):component (2):component (3) is 65-85:7.5-20:7.5-17.5. In still another embodiment, the molar ratio of component (1):component (2):component (3) is 75-85:10-20:5-15.

Examples of Crosslinking Agents; and Clad and Core Formulations:

The following examples are detailed descriptions of methods of preparation and use of certain compositions of the present invention. The detailed preparation descriptions fall within the scope of, and serve to exemplify, the more generally described compositions and formulations set forth above.

Additionally, in the examples below Lithium tetrakis (pentafluoro phenyl borate) • 2.5 etherate is sometimes referred to in shorthand as LiFABA (see for example Table 2), and (allyl)palladium(tricyclohexylphosphine)trifluoroacetate is referred to as Allyl Pd-PCy₃TFA.

X. Examples of Formation of Selected Crosslinking Agents:**(X1) Synthesis of dimethyl bis(norbornenemethoxy) silane:**

Norbornene methanol (108.5 g, 0.87 mol.) is added dropwise to bis(dimethylamino) dimethyl silane (63.97g, 0.43 mol.) in a reactor which is connected to a scrubber containing dilute hydrochloric acid. The reaction mixture is stirred for about 4 hours. The mixture is then connected to a vacuum, and residual amounts of the amine are removed. Pure product is obtained by distillation under vacuum (117g, ~90% yield).

The above reaction is also carried out using the dimethyl dichloro silane instead of bis(dimethylamino) dimethyl silane

To a vigorously stirred mixture of 5-norbornene methanol (50g, 0.40 mol.), triethyl amine (49g, 0.49 mol.) and toluene (400 mL), dimethyl dichlorosilane (25.8g, 0.20 mol.) is added dropwise. Stirring at room temperature results in the formation of salts. The crude product is isolated by filtration of the salts, washing the toluene solution with water (3 times) followed by evaporation of toluene. Distillation is conducted under vacuum to obtain pure product (53g, ~87% yield)

(X2) Synthesis of octamethyl 1,8-bis(norbornenemethoxy) tetrasiloxane:

Norbornenemethanol (21.2g, 0.17 mol.) is added dropwise to a solution consisting of octamethyl dichlorotetrasiloxane (30g, 0.085 mol.), triethyl amine (21g, 0.21 mol.) and toluene (300 mL). The reaction mixture is stirred for 8 hours at room

temperature. The solids that are formed (triethylamine hydrochloride) are filtered off. The toluene solution is then washed 3 times with small amounts of distilled water and the crude product is obtained by removing the toluene. Pure product is obtained by distillation under vacuum (39g, ~ 87% yield).

5 (X3) Synthesis of Bis(norbornenemethyl)acetal:

A mixture of norbornenemethanol (100g, 0.81 mol.), formaldehyde (~37%) (32.6g, 0.40 mol.) and a catalytic amount of p-toluene sulfonic acid (0.2g) are heated at 100 °C in a flask which is directly connected to a Dean Stark Trap. As the reaction proceeds, the amount of water in the trap increases. Within about 3 hours,
10 the reaction is complete. Pure product is obtained by distilling under vacuum (72.8g, ~70% yield).

Examples of Clad Formulations (one Component):

CL1: Cladding Formulation using octamethyl 1,8-bis(norbornenemethoxy) tetrasiloxane:

15 Lithium tetrakis (pentafluoro phenyl borate) • 2.5 etherate (0.0200g, 2.3×10^{-5} mol.) is dissolved in a mixture of monomers consisting of hexylnorbornene (10g, 0.056 mol.) octamethyl 1,8-bis(norbornenemethoxy) tetrasiloxane (3.9g, 8.6 mmol.) and triethoxysilylnorbornene (2.9g, 0.011mol.). To the mixture is added 0.17g of Irganox® 1076 (1 % by weight).

20 To this mixture, is added 0.16 mL of catalyst stock solution (3.02×10^{-6} mol.). (Note: the stock solution was made up by dissolving 0.01g of Allyl Pd-PCy₃TFA in 1 mL of dry dichloromethane.)

25 Cure/post-cure is conducted according to the following schedule: 10 min. at 65 °C and 60 min. at 160 °C. After curing the monomer mixture, a clear and good optical quality film is obtained.

CL2: Cladding Formulation using Bis(norbornenemethyl)acetal:

30 Lithium tetrakis (pentafluoro phenyl borate) • 2.5 etherate (0.0042g, 4.8×10^{-6} mol.) is dissolved in a mixture of monomers consisting of hexylnorbornene (5g, 0.028 mol.), bis(norbornenemethyl)acetal (1.57, 6.1 mmol.) and triethoxysilylnorbornene (1.54, 6.1 mmol.). To this mixture is added 0.08g of Irganox® 1076 (1 % by weight).

To this mixture, added 0.08 mL of catalyst stock solution (1.6×10^{-6} mol.).
(Note: the stock solution was made up by dissolving 0.01g of Allyl Pd-PCy₃TFA in 1 mL of dry dichloromethane.)

5 Cure/post-cure is conducted according to the following schedule: 10 min. at 65 °C and 60 min. at 160 °C. After curing the monomer mixture, a clear and good optical quality film is obtained.

CL3: Cladding Formulation using F-Crosslinking Agent I:

10 Lithium tetrakis (pentafluoro phenyl borate) • 2.5 etherate (0.0061g, 6.9×10^{-6} mol.) is dissolved in a mixture of monomers consisting of hexyl norbonene (6.2g, 0.035 mol), F-Crosslinking Agent I (3.2g, 4.3 mmol.) and triethoxysilylnorbornene (1.11g, 4.3 mmol.). To the mixture is added 0.10g of Irganox® 1076 (1 % by weight).

15 To this mixture, added 0.1 mL of catalyst stock solution (1.7×10^{-6} mol.).
(Note: the stock solution was made up by dissolving 0.01g of Allyl Pd-PCy₃TFA in 1 mL of dry dichloromethane.)

20 Cure/post-cure is conducted according to the following schedule: 10 min. at 65 °C and 60 min. at 160 °C. After curing the monomer mixture, a clear and good optical quality film is obtained.

CL4: Cladding Formulation using F-Crosslinking Agent II:

25 Lithium tetrakis (pentafluoro phenyl borate) • 2.5 etherate (0.0061g, 6.9×10^{-6} mol.) is dissolved in a mixture of monomers consisting of hexyl norbonene (6.2g, 0.035 mol), F-Crosslinking Agent II (3.6g, 4.3 mmol.) and triethoxysilylnorbornene (1.11g, 4.3 mmol.). To this mixture is added 0.10g of Irganox® 1076 (1 % by weight).

30 To this mixture, added 0.1 mL of catalyst stock solution (1.7×10^{-6} mol.).
(Note: the stock solution was made up by dissolving 0.01g of Allyl Pd-PCy₃TFA in 1 mL of dry dichloromethane.)

35 Cure/post-cure is conducted according to the following schedule: 10 min. at 65 °C and 60 min. at 160 °C. After curing the monomer mixture, a clear and good optical quality film is obtained.

Example of Clad Formulation (two Component) CL5:

All monomers are degassed using dry nitrogen gas prior to use.

Component A:

5 To a mixture of hexyl norbornene (33g, 0.185 mol.), triethoxysilyl norbornene (9.5g, 0.037 mol.) and dimethyl bis(norbornene methoxy) silane (7.5g, 0.0247mol.) is added Allyl Pd-PCy₃TFA (0.0107g, 1.98×10^{-5} mol.) dissolved in 0.2 ml of dichloromethane. To this mixture is added 0.50g of Irganox® 1076.

Component B:

10 Lithium tetrakis (pentafluoro phenyl borate) • 2.5 etherate (0.0689g, 7.91×10^{-5} mol.) is dissolved in a mixture of triethoxysilyl norbornene (9.5g, 0.037 mol.) and dimethyl bis(norbornene methoxy) silane (7.5g, 0.0247mol.). Once the solids are completely dissolved, hexyl norbornene (33g, 0.185 mol.) is added to the mixture. Also added to the mixture, and dissolved therein, is Irganox® 1076 (0.50g). In addition to the antioxidant, 0.25 g of Irgafos® 168 is added as a synergist.

15 Equal amounts of Components A and B are mixed together and are cured. Cure/post-cure is conducted according to the following schedule: 10 min. at 65 °C and 60 min. at 160 °C. After curing the monomer mixture, a clear and good optical quality film is obtained.

The formulation of this example is shown in Table 2 below.

TABLE 2			
Compound	Component (A) (g)	Component B (g)	Total Moles in A and B
Hexyl Norbornene	33	33	0.3708
Triethoxysilyl Norbornene	9.5	9.5	0.0742
Dimethyl Bis(Norbornene Methoxy) Silane	7.5	7.5	0.0493
Total Moles	N/A	N/A	0.4943
LiFABA	N/A	0.0689	7.91×10^{-5}
Ally Pd-PCy ₃ TFA	0.0107	N/A	1.98×10^{-5}
Irganox [®] 1076	0.50	0.50	
Irgafos [®] 168	N/A	0.25	

CO1. Example of Core Formulations (two Component):

All monomers are degassed using dry nitrogen gas prior to use.

Component A:

To a mixture of hexyl norbornene (31.5g, 0.18 mol.), diphenyl methyl norbornene methoxy silane (11.3g, 0.035 mol.) and dimethyl bis(norbornene methoxy) silane (7.5g, 0.025mol.), is added Allyl Pd-PCy₃TFA (0.0102g, 1.89×10^{-5} mol.) dissolved in 0.2 ml of dichloromethane. To this mixture is added 0.50g of Irganox[®] 1076.

Component B:

Lithium tetrakis (pentafluoro phenyl borate) • 2.5 etherate (0.0658g, 7.55×10^{-5} mol.) is dissolved in a mixture of diphenyl methyl (norbornene methoxy) silane (11.3g, 0.035 mol.) and dimethyl bis(norbornene methoxy) silane (7.5g, 0.0247 mol.)

and hexyl norbornene (31.5g, 0.18 mol.). To this mixture is added, and dissolved therein, Irganox® 1076 (0.50g). In addition to the antioxidant, 0.25 g of Irgafos® 168 is added as a synergist.

Equal amounts of Components A and B are mixed together and are cured. Cure/post-cure is conducted according to the following schedule: 10 min. at 65 °C and 60 min. at 160 °C. After curing the monomer mixture, a clear and good optical quality film is obtained.

The formulation of this example is shown in Table 3 below.

TABLE 3			
Compound	Component (A) (g)	Component B (g)	Total Moles in A and B
Hexyl Norbornene	31.5	31.5	0.3539
Diphenyl Methyl (Norbornene Methoxy) Silane	11.3	11.3	0.0706
Dimethyl Bis(Norbornene Methoxy) Silane	7.2	7.2	0.0474
Total Moles	N/A	N/A	0.4719
LiFABA	N/A	0.0658	7.55×10^{-5}
Ally Pd-PCy ₃ TFA	0.0102	N/A	1.89×10^{-5}
Irganox® 1076	0.50	0.50	
Irgafos® 168	N/A	0.25	

Methods of Curing Cyclic Olefin Monomer**Formulations and Producing Waveguides:****Cure/Post-Cure:**

As discussed above under the Mass Process heading, the monomer
5 formulations of the present invention are polymerized at a temperature of about
20 °C to about 200 °C for about 1 minute to about 2 hours. In another embodiment,
the polymerization occurs at a temperature of about 20 °C to about 120 °C for about
1 to about 40 minutes. In yet another embodiment, polymerization occurs at a
temperature of about 40 °C to about 80 °C for about 5 minutes to about 20 minutes.
10 As noted above, the polymerization reaction can be carried out under an inert
atmosphere such as nitrogen or argon. In another embodiment, the polymerization
can be carried out in a forced air, vented oven.

After polymerization, the polymer may be subjected to a post curing step. In
one embodiment, the post curing step is conducted for about 1 to about 2 hours at a
15 temperature range of from about 100 °C to about 300 °C (as noted above the
temperature during post-cure can be increased over time). Additionally, in another
embodiment, post-cure can be conducted for about 0.5 to about 4 hours at a
temperature in the range of from about 100 °C to about 300 °C. In another
embodiment, the post curing step is conducted for about 1 to about 2 hours over a
20 temperature range (or at a temperature in the range) of from about 125 °C to about
200 °C. In still another embodiment, the post curing step is conducted for about 1 to
about 2 hours over a temperature range of (or at a temperature in the range) from
about 140 °C to about 180 °C.

Partial Cure/Cure/Post Cure:

25 In another embodiment, at least one monomer formulation (e.g., either a core
composition or a cladding (or clad) composition) is partially polymerized (cured) to
gel point at a temperature of about 20 °C to about 120 °C for about 0.1 to about 10
minutes. In another embodiment, the polymerization occurs at a temperature of
about 40 °C to about 100 °C for about 1 to about 8 minutes. In yet another
30 embodiment, polymerization occurs at a temperature of about 50 °C to about 70 °C

for about 2 minutes to about 6 minutes. As noted above, the polymerization reaction can be carried out under an inert atmosphere such as nitrogen or argon. In another embodiment, the polymerization can be carried out in a forced air, vented oven.

After partial cure, at least one more monomer formulation (not cured) can be placed over or on top of the partially cured monomer formulation(s). In one embodiment, if at least one core composition is subjected to partial cure, then at least one clad composition is placed over the at least one core composition. In another embodiment, if at least one clad composition is subjected to partial cure, then at least one core composition is placed over the at least one core composition. In yet another embodiment, the at least one monomer formulation which is placed over the at least one partially cured monomer formulation can be another similar formulation (i.e., at least one additional core formulation over the at least one partially cured core formulation, etc.).

After the desired combination of monomer formulations is present (at least one of which is partially cured in accordance with the above discussion) the combination is cured at a temperature of about 20 °C to about 200 °C for about 1 minute to about 2 hours. In another embodiment, the polymerization occurs at a temperature of about 20 °C to about 120 °C for about 1 to about 40 minutes. In yet another embodiment, polymerization occurs at a temperature of about 40 °C to about 80 °C for about 5 minutes to about 20 minutes. As noted above, the polymerization reaction can be carried out under an inert atmosphere such as nitrogen or argon. In another embodiment, the polymerization can be carried out in a forced air, vented oven.

After the combination of monomers has been cured (polymerized), the polymer combination may be subjected to a post curing step. In one embodiment, the post curing step is conducted for about 1 to about 2 hours at a temperature range of from about 100 °C to about 300 °C (as noted above the temperature during post-cure can be increased over time). Additionally, in another embodiment, post-cure can be conducted for about 0.5 to about 4 hours at a temperature in the range of from about 100 °C to about 300 °C. In another embodiment, the post curing step

is conducted for about 1 to about 2 hours over a temperature range (or at a temperature in the range) of from about 125 °C to about 200 °C. In still another embodiment, the post curing step is conducted for about 1 to about 2 hours over a temperature range of (or at a temperature in the range) from about 140 °C to about 180 °C.

Method of Making Waveguides:

Clad First:

Conventional molding processes of fabrication of waveguides are done in a clad-first fashion. For example, shown in Figure 1 is a generic process of making a waveguide 1. First at (a) a cladding film 12 (sub-cladding) is formed by casting against a master 10 (a nickel master or other suitable master) in a molding process such as injection molding, hot embossing and reactive casting (see (a) of Figure 1) and subsequently subjected to curing. The sub-cladding layer 12 is removed from the master 10 (see (b) of Figure 1) and a liquid core material 14 is then applied onto the featured side of the sub-cladding film 12 and forced into the grooves by pressure using, for example, a Doctor blade 16 (see (c) of Figure 1). Thereafter, the liquid core material 14 is cured to form a ribbed waveguide structure 14a (see (d) of Figure 1). It should be noted that the waveguide structure depicted in Figure 1 is ribbed. However, any suitable waveguide structure can be formed (e.g., a web, lattice, matrix, buried channels, etc.). Next, a top cladding layer 18 is formed over a portion or all of the waveguide structure 14a by depositing thereupon a liquid clad material which upon curing forms the top cladding layer 18 (see (e) of Figure 1).

Alternatively, the top cladding layer 18 may be formed independently rather than being polymerized from a liquid formulation placed on top of the waveguide structure 14a, and optionally a portion of the sub-cladding layer 12. In such an embodiment, the top cladding layer 18 may be joined to the exposed portion of the waveguide structure 14a using a suitable adhesive attachment means (e.g., a layer of liquid cladding material which acts as a glue).

In yet another embodiment, the method of Figure 1 can be halted after step (d) has been completed. In such a case, a two layer waveguide is obtained rather than the three layer wave guide discussed above.

Using one of the above clad-first approaches results in the production of two and three layer waveguides. Additionally, this conventional clad-first approach can yield a variety of waveguide structures such as an array of buried rib waveguides, as shown in Figures 2A to 2C. A careful balance of the dimensions (height, width, spacing, and thickness of the slab region) of the rib guides, along with control over the difference in the refractive index between the core and clad layers, and the operating wavelength can lead to a waveguide structure in which light is well confined (Figures 2B and 2C).

It should be noted that core/clad compositions disclosed herein can be used in other prior art waveguide formation methods (*e.g.*, micro-molding/embossing; reactive ion etching; UV laser and e-beam writing; photochemical delineation; photo-bleaching; induced dopant diffusion (photo-induced dopant diffusion, photolocking and selective polymerization); selective poling of electro-optically active molecules induced by an electric field; and polymerization of self-assembled prepolymers

Additionally, the master used in this embodiment may have a waveguide structure whose channels are actually bigger than desired in the final product. Such features permit a non-stick coating (*e.g.*, PTFE) or a mold-release agent to be applied over the master so as to facilitate removal of the sub-cladding layer 12 from the master 10. Alternatively, separation of the sub-cladding layer from the master may be facilitated by running cold water over the sub-cladding layer.

Core-First Method:

Using the core-first method discussed below, a waveguide, even an isolated buried channel wave guide, can be formulated. For the purposes of this discussion, the method will be discussed in relation to an isolated buried channel waveguide. However, it is within the scope of this invention to form other waveguide structures (such as a ribbed structure).

Compared with the conventional clad-first approach, the fabrication steps in the core-first approach are executed in reverse order, as shown in Figure 3. The general process is described as follows. A mixture of a core material 30 is poured onto the surface of a master 32 (e.g., Ni, Si masters, etc.) having grooves 34 formed in the shape and dimensions of the desired waveguide pre-structure (see (a) and (b)). For example, for an isolated buried channel waveguide structure the channels are from about 1 μm to about 200 μm in width and from about 1 μm to about 200 μm in height. However, any desired thickness and height may be obtained so long as the channels are neither too narrow or too shallow to accept the core material.

A Doctor blade 36 is set to rest directly on the surface of the master (where a buried structure is desired) and used to scrape away the excess liquid core mixture 30 (see (b) of Figure 3). Next, the core material 30 left in the grooves is cured to form at least one waveguide structure 30a. If the core material 30 is one of the core materials described above, the core material 30 can be cured in accordance with any one of the above-mentioned methods.

After the core material 30 left in the grooves is fully cured, as described above (see (c) of Figure 3), a mixture of a cladding material 38 is poured onto the top of the core containing master so as to cover the at least one exposed surface of the waveguide structure(s) 30a. The thickness of the sub-cladding layer is also controlled by a Doctor blade 36 (see (d) of Figure 3). Upon curing under the proper conditions, a sub-clad layer 40 is formed which is in contact with at least one surface of the waveguide structure(s) (see (e) of Figure 3). Next, the sub-clad layer 40/waveguide structure(s) 30a combination is removed from the master 32 and flipped over so that the sub-clad layer is on the bottom (see (f) of Figure 3).

In one embodiment, the thickness of sub-clad layer is sufficient to allow for the removal of the sub-clad layer 40 and the waveguide structure(s) 30a from the master 32 without causing damage thereto. In another embodiment, the thickness of the each clad (sub-clad and top clad) is from about 2 μm to about 20,000 μm or are in total about 4 μm to about 20,000 μm . In yet another embodiment, the

thickness of each clad layer is about 10 μm to about 10,000 μm , or are in total about 20 μm to about 10,000 μm . It should be noted that the height of the top-clad by definition includes the height of the core layer (see (h) of Figure 3).

Next, a top cladding material 42 is applied to the core side of the film and the thickness thereof is also controlled by a Doctor blade 36 (see (g) of Figure 3).

Thereafter, the top cladding material 42 is cured to form a top cladding layer 42a. Upon completion of the curing process of the top cladding layer a waveguide 50 is formed (see (h) of Figure 3). It should be noted, that curing of this third layer results in a three-layer polymer film containing isolated channel waveguide core 30a buried between the sub-cladding layer 40 and the top cladding layer 42a.

Alternatively, if a two layer optical waveguide is desired the above process is halted after step (f) is complete.

Additionally, the master used in this embodiment may have a core structure(s) which are actually bigger than desired in the final product. Such features permit a non-stick coating (e.g., PTFE) or a mold-release agent to be applied over the master to help facilitate the removal of the core structures 30a and the sub-cladding layer 40 from the master 32. Alternatively, separation of the sub-cladding layer from the master is facilitated by running cold water over the sub-cladding layer.

Compared with the clad-first approach, this core-first approach makes the core structures of waveguides by casting on a master (e.g., Ni or Si) that has no interaction with the liquid core precursor. This modification in the fabrication process permits the complete removal of the slab region of the core layer and also enables an easy filling of fine channels by using a low-viscosity core prepolymer mixture, which simplifies the production of isolated, buried channel waveguides.

Optical micrographs of samples of two-layer and three-layer waveguide structures made using the core-first method are shown in Figures 4A to 4D and, in one embodiment, the previously discussed cyclic olefin compositions (e.g., using the core and clad formulations discussed above). The waveguides of Figures 4A to 4D were produced using the clad composition detailed in Table 2 above, and the core composition detailed in Table 3 above. Figure 4A shows a two-layer isolated

channel waveguide structure; Figure 4B shows a three-layer buried channel waveguide structure; Figure 4C is a schematic diagram of the end view of the waveguide array of Figure 4B (dimensions 13 μm wide, 16 μm tall, spaced by 13 μm) with the position of an input optical fiber shown as a shaded circle; and Figure 4D is a photograph of the waveguide output when light from a diode laser ($\lambda = 820$ nm) is coupled into a single core structure 30a as shown in Figure 4C. The output pattern shows that the guide is multimode at 820 nm and there is no cross coupling between adjacent guides.

The core-first method is also applicable to any other suitable polymer system which include, but are not limited to, polyacrylates (such as deuterated polyfluoromethacrylate), polyimides (such as cross-linked polyimides or fluorinated polyimides), or benzocyclobutene.

With regard to Figures 5A and 5B, these figures depict the condition called "swelling". "Swelling" may occur during a clad-first approach for forming waveguides (see Figure 1). Although not wishing to be bound to any one theory, it is believed that swelling occurs during the polymerization of the core composition in the previously polymerized sub-cladding structure. In some instances "swelling" may be undesirable. Thus, using, for example, the above-mentioned core-first approach to waveguide formation (see Figure 3) it is possible to reduce and/or eliminate such "swelling". This is shown by comparing Figure 5A (formed using the above-mentioned clad-first approach) to that of Figure 5B (formed using the above-mentioned core-first approach).

Modified Core-First Method:

In another embodiment, the above-mentioned core first method can be modified to take advantage of the previously discussed partial cure/cure/postcure polymerization method (see above). For the purposes of this discussion, the method will be discussed in relation to an isolated buried channel waveguide. However, it is within the scope of this invention to form other waveguide structures (such as a ribbed structure).

This modified core first method will be discussed with reference to Figures 6, 7A and 7B. Referring to Figure 6, the general modified core first process is described as follows. A mixture of a core material 60 is poured onto the surface of a master 62 (e.g., Ni, Si masters, etc.) having grooves 64 formed in the shape and dimensions of the desired waveguide structure (see (a) and (b)). For example, for an isolated buried channel waveguide structure the channels are from about 1 μm to about 200 μm in width and from about 1 μm to about 200 μm in height. However, any desired thickness and height may be obtained so long as the channels are neither too narrow or too shallow to accept the core material.

A Doctor blade 66 is set to rest directly on the surface of the master (where a buried structure is desired) and used to scrape away the excess liquid core mixture 60 (see (b) of Figure 6). Next, the core material 60 left in the grooves is partially cured to form at least one pre-waveguide structure 60a. If the core material 60 is one of the core materials described above, the core material 60 is partially cured in accordance with the above-mentioned partial cure/cure/post cure method.

After the core material 60 left in the grooves is partially cured, as described above (see (c) of Figure 6), a mixture of a cladding material 68 is poured onto the top of the core containing master so as to cover the at least one exposed surface of the waveguide structure(s) 60a. The thickness of the sub-cladding layer is also controlled by a Doctor blade 66 (see (d) of Figure 6). Upon curing under the proper conditions (see the discussion under partial cure/cure/post cure above), a sub-clad film 70 is formed which is in contact with at least one surface of the waveguide structure(s) (see (e) of Figure 6). Next, the sub-clad layer 70/waveguide structure(s) 60a combination is removed from the master 62 and flipped over so that the sub-clad layer is on the bottom (see (f) of Figure 6).

In one embodiment, the thickness of sub-clad layer is sufficient to allow for the removal of the sub-clad layer 70 and the waveguide structure(s) 60a from the master 62 without causing damage thereto. In another embodiment, the thickness of the each clad (sub-clad and top clad) is from about 2 μm to about 20,000 μm or are in total 4 μm to about 20,000 μm . In yet another embodiment, the thickness of each

clad layer is about 10 μm to about 10,000 μm , or are in total about 20 μm to about 10,000 μm . It should be noted that the height of the top-clad by definition includes the height of the core layer (see (h) of Figure 6).

Next, a top cladding material 72 is applied to the core side of the film and the thickness thereof is also controlled by a Doctor blade 66 (see (g) of Figure 6).

Thereafter, the top cladding material 72 is cured to form a top cladding layer 72a. Upon completion of the curing process of the top cladding layer a waveguide 75 is formed (see (h) of Figure 6). It should be noted, that curing of this third layer results in a three-layer polymer film containing isolated channel waveguide core 60a buried between the sub-cladding layer 70 and the top cladding layer 72a.

Alternatively, if a two layer optical waveguide is desired the above process is halted after step (f) is complete.

Additionally, the master used in this embodiment may have a core structure(s) which are actually bigger than desired in the final product. Such features permit a non-stick coating (e.g., PTFE) or a mold-release agent to be applied over the master to help facilitate the removal of the core structures 60a and the sub-cladding layer 70 from the master 62. Alternatively, separation of the sub-cladding layer from the master is facilitated by running cold water over the sub-cladding layer.

Compared with the clad-first approach, this modified core-first approach also makes the core structures of waveguides by casting on a master (e.g., Ni or Si) that has no interaction with the liquid core precursor. This modification in the fabrication process permits the complete removal of the slab region of the core layer and also enables an easy filling of fine channels by using a low-viscosity core prepolymer mixture, which simplifies the production of isolated, buried channel waveguides. Additionally, the modified core-first method reduces the amount of curing time necessary to produce a waveguide and reduces the amount of evaporation of the liquid core layer during the curing process thereby yielding fully filled buried waveguide structures. Optical micrographs of samples of two two-layer waveguide

structures made using the core-first method (Figure 7A) and the modified core first method (Figure 7B) confirm that the modified core-first method permits the formation of fully filled buried waveguide structures.

Multilayer Cutting Method:

5 As shown in Figure 8, a double-layer polymer film 80 containing a thin layer of core material 82 (e.g., 25 μm) on top of a thick layer 84 of sub-cladding material (e.g., 100 μm thick) can be easily fabricated in a conventional film casting process. These layers may also be thicker or thinner as is discussed in relation to the thickness of the layers in the core-first method.

10 Next, a master 86 having designed features 88a or 88b therein is used to form a modified core layer 82a or 82b having openings 90a or 90b therein. As shown in Figure 8, the openings 90a or 90b in modified core layer 82a or 82b penetrate through the core layer 82 and into the sub-cladding layer 84. In this method formation of the features in the core and cladding layers are accomplished
15 by any suitable cutting technique (e.g., hot embossing, diamond cutting, laser ablation or reactive-ion etching (RIE), etc.). After formation of the modified core layer 82a or 82b, a top cladding layer is formed by applying a top cladding material to the double-layer polymer film having modified core layer 82a or 82b with openings 90a or 90b formed therein. The top cladding material is cured using any suitable method
20 to yield a top cladding layer 92. During the formation of the top cladding layer 92, the top cladding material fills in the openings 90a or 90b so as to complete the formation of the buried waveguides 94a and 94b.

25 Buried waveguides 94a and 94b contain isolated core structures sandwiched between layers of, or surrounded by, or buried within the sub- and top cladding materials. Such waveguides can be used as basic components of integrated optical circuits in optoelectronic markets.

 In another embodiment, a triple layer polymer film (i.e. a clad-core-clad multilayered film) is used to form a waveguide according to the method detailed in Figure 8.

This fabrication approach is also applicable to not only the cyclic olefin monomer compositions discussed herein, but other polymer systems such as polyacrylates (such as deuterated polyfluoro-methacrylate), polyimides (such as cross-linked polyimides or fluorinated polyimides), or benzocyclobutene. In addition, other polymers may be used. These polymers include, but are not limited to, heat-curable mass polymerizable materials, photo-curable polymers and solution-based polymer materials.

Figures 9A to 9D are other examples of waveguides formed using a multilayer cutting method and the above discussed core/clad formulations. Figure 9A is an optical micrograph of a two-layer isolated channel waveguide formed using the multi-layer cutting method; Figure 9B depicts light from a diode laser ($\lambda = 820$ nm) being applied to the middle isolated channel structure of the waveguide of Figure 9A; Figure 9C is a three-layer isolated-buried channel waveguide formed by taking the two or three layer structure formed by the cutting method and overcoating the structure with clad material; and Figure 9D depicts light from a diode laser ($\lambda = 820$ nm) being applied to the middle isolated-buried channel structure of the waveguide of Figure 9C. It should be noted that when the photographs of Figures 9B and 9D were taken that the intensity of the input light from the diode laser is maximized to ascertain if any cross-talk exists between the isolated-buried waveguide structures. As can be seen from Figures 9B and 9D, the output patterns indicate that there is no cross coupling between adjacent waveguide structures.

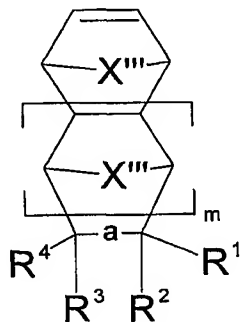
Although the invention has been shown and described with respect to a certain preferred embodiment or embodiments, it is obvious that equivalent alterations and modifications will occur to others skilled in the art upon the reading and understanding of this specification and the annexed drawings. In particular regard to the various functions performed by the above described integers (components, assemblies, devices, compositions, etc.), the terms (including a reference to a "means") used to describe such integers are intended to correspond, unless otherwise indicated, to any integer which performs the specified function of the described integer (*i.e.*, that is functionally equivalent), even though not

structurally equivalent to the disclosed structure which performs the function in the herein illustrated exemplary embodiment or embodiments of the invention. In addition, while a particular feature of the invention may have been described above with respect to only one of several illustrated embodiments, such feature may be
5 combined with one or more other features of the other embodiments, as may be desired and advantageous for any given or particular application.

CLAIMS:

What is claimed is:

1. A polycyclic polymer composition formed from one or more monomers or oligomers represented by the following structure:



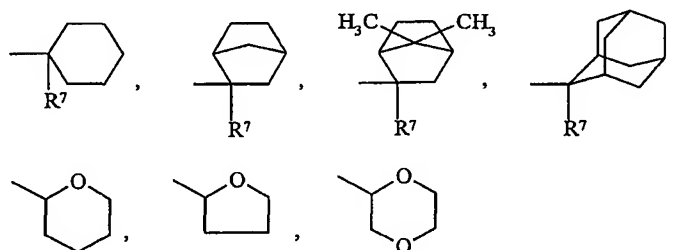
wherein each X''' independently represents oxygen, nitrogen, sulfur, or a methylene group of the formula $-(CH_2)_{n'}$ where n' is an integer of 1 to 5; "a" represents a single or double bond; R^1 to R^4 independently represent a hydrogen, a hydrocarbyl, or a functional substituent; and m is an integer from 0 to 5, with the proviso that when "a" is a double bond one of R^1 , R^2 and one of R^3 , R^4 are not present.

2. The polymer composition of claim 1, provided that when any of R^1 to R^4 is a hydrocarbyl group, R^1 to R^4 independently comprises a hydrocarbyl, a halogenated hydrocarbyl or a perhalogenated hydrocarbyl group which are selected from: i) linear or branched C_1 - C_{10} alkyl groups; ii) linear or branched C_2 - C_{10} alkenyl groups; iii) linear or branched C_2 - C_{10} alkynyl groups; iv) C_4 - C_{12} cycloalkyl groups; v) C_4 - C_{12} cycloalkenyl groups; vi) C_6 - C_{12} aryl groups; and vii) C_7 - C_{24} aralkyl groups.

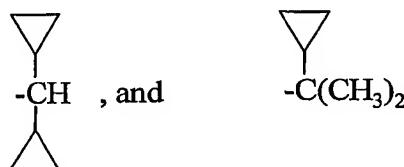
3. The polymer composition of claim 1, wherein X^{'''} is nitrogen having a hydrogen or a C₁ to C₁₀ alkyl group.

4. The polymer composition of claim 1, wherein R¹ and R², or R³ and R⁴ are taken together to represent a C₁-C₁₀ alkylidenyl group.

5. The polymer composition of claim 1, wherein one or more of R¹ to R⁴ represent a functional substituent independently selected from
 $-(CH_2)_n-CH(CF_3)_2-O-Si(Me)_3$, $-(CH_2)_n-CH(CF_3)_2-O-CH_2-O-CH_3$,
 $-(CH_2)_n-CH(CF_3)_2-O-C(O)-O-C(CH_3)_3$, $-(CH_2)_n-C(CF_3)_2-OH$, $-(CH_2)_n-C(O)NH_2$,
 $-(CH_2)_n-C(O)Cl$, $-(CH_2)_n-C(O)OR^5$, $-(CH_2)_n-OR^5$, $-(CH_2)_n-OC(O)R^5$, $-(CH_2)_n-C(O)R^5$,
 $-(CH_2)_n-OC(O)OR^5$, $-(CH_2)_nSi(R^5)_3$, $-(CH_2)_nSi(OR^5)_3$, $-(CH_2)_n-O-Si(R^5)_3$, and
 $-(CH_2)_n-C(O)OR^6$, wherein n independently represents an integer from 0 to 10, R⁵ independently represents a hydrogen, a linear or branched C₁-C₂₀ alkyl group, a linear or branched C₁-C₂₀ halogenated or perhalogenated alkyl group, a linear or branched C₂-C₁₀ alkenyl group, a linear or branched C₂-C₁₀ alkynyl group, a C₅-C₁₂ cycloalkyl group, a C₆-C₁₄ aryl group, a C₆-C₁₄ halogenated or perhalogenated aryl group, and a C₇-C₂₄ aralkyl group; and R⁶ is selected from $-C(CH_3)_3$, $-Si(CH_3)_3$, $-CH(R^7)OCH_2CH_3$, $-CH(R^7)OC(CH_3)_3$ or one of the following cyclic groups:



or one of the following:



wherein R⁷ represents a hydrogen or a linear or branched (C₁ - C₅) alkyl group.

6. The polymer composition of claim 4, wherein R⁵ is a halogenated or perhalogenated group.

7. The polymer composition of claim 1, wherein R¹ and R⁴ are taken together with the two ring carbon atoms to which they are attached to represent a substituted or unsubstituted cycloaliphatic group containing 4 to 30 ring carbon atoms or a substituted or unsubstituted aryl group containing 6 to 18 ring carbon atoms or combinations thereof.

8. The polymer composition of claim 6, wherein the cycloaliphatic group is a monocyclic or polycyclic cycloaliphatic group.

9. The polymer composition of claim 7, wherein the cycloaliphatic group is monounsaturated or multiunsaturated.

10. The polymer composition of claim 1, wherein the composition is a homopolymer.

11. The polymer composition of claim 1, wherein the composition is a co-polymer comprising at least two different repeating units according to the structure of claim 1.

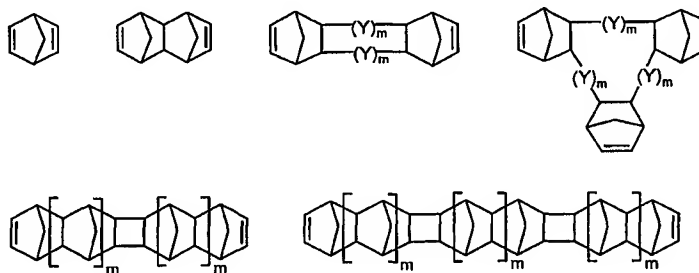
12. The polymer composition of claim 1, wherein the number of repeating units in the composition is from about 100 to about 100,000.

13. The polymer composition of claim 1, wherein the number of repeating units in the composition is from about 500 to about 50,000.

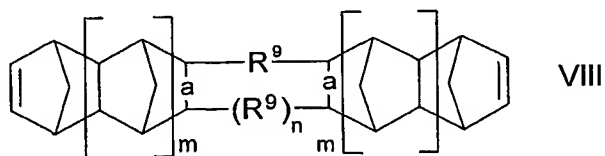
14. The polymer composition of claim 1, wherein the number of repeating units in the composition is from about 1,000 to about 10,000.

15. The polymer composition of claim 1, wherein the polymer composition is formed from one or more monomers or oligomers according to claim 1 in combination with one or more crosslinking agents.

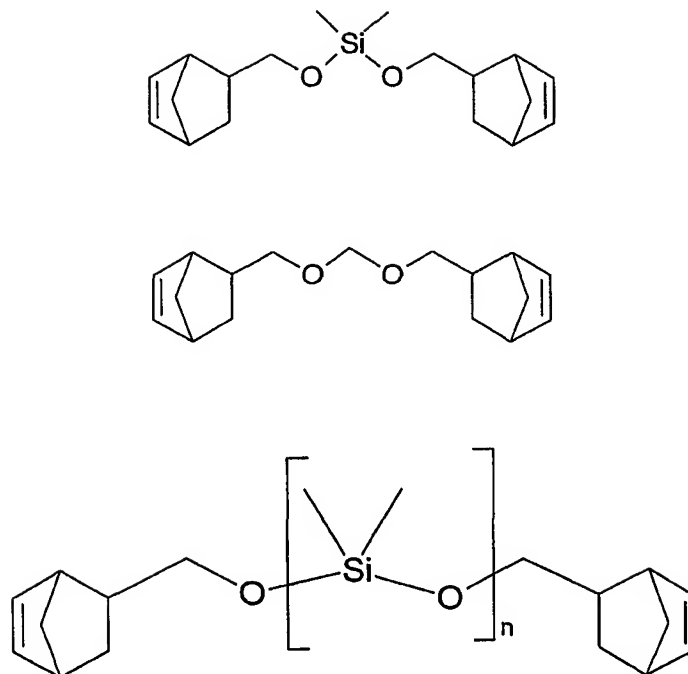
16. The polymer composition of claim 15, wherein the crosslinking agent is selected from at least one of the following structures:



wherein Y represents a methylene ($-\text{CH}_2-$) group and m independently represents an integer from 0 to 5, and when m is 0, Y represents a single bond; a linked multicyclic crosslinking agent as shown in Structure VIII below:

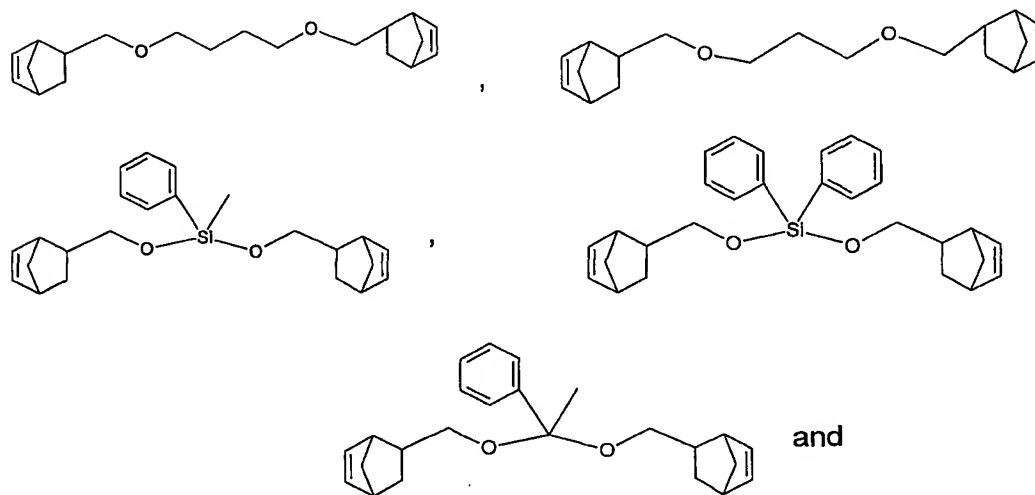


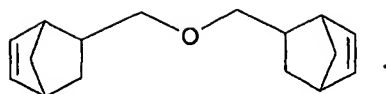
wherein "a" independently represents a single or double bond, m independently is an integer from 0 to 5, R^9 is a divalent radical selected from divalent hydrocarbyl radicals, divalent ether radicals and divalent silyl radicals, and n is 0 or 1; or a crosslinking agent as shown below:



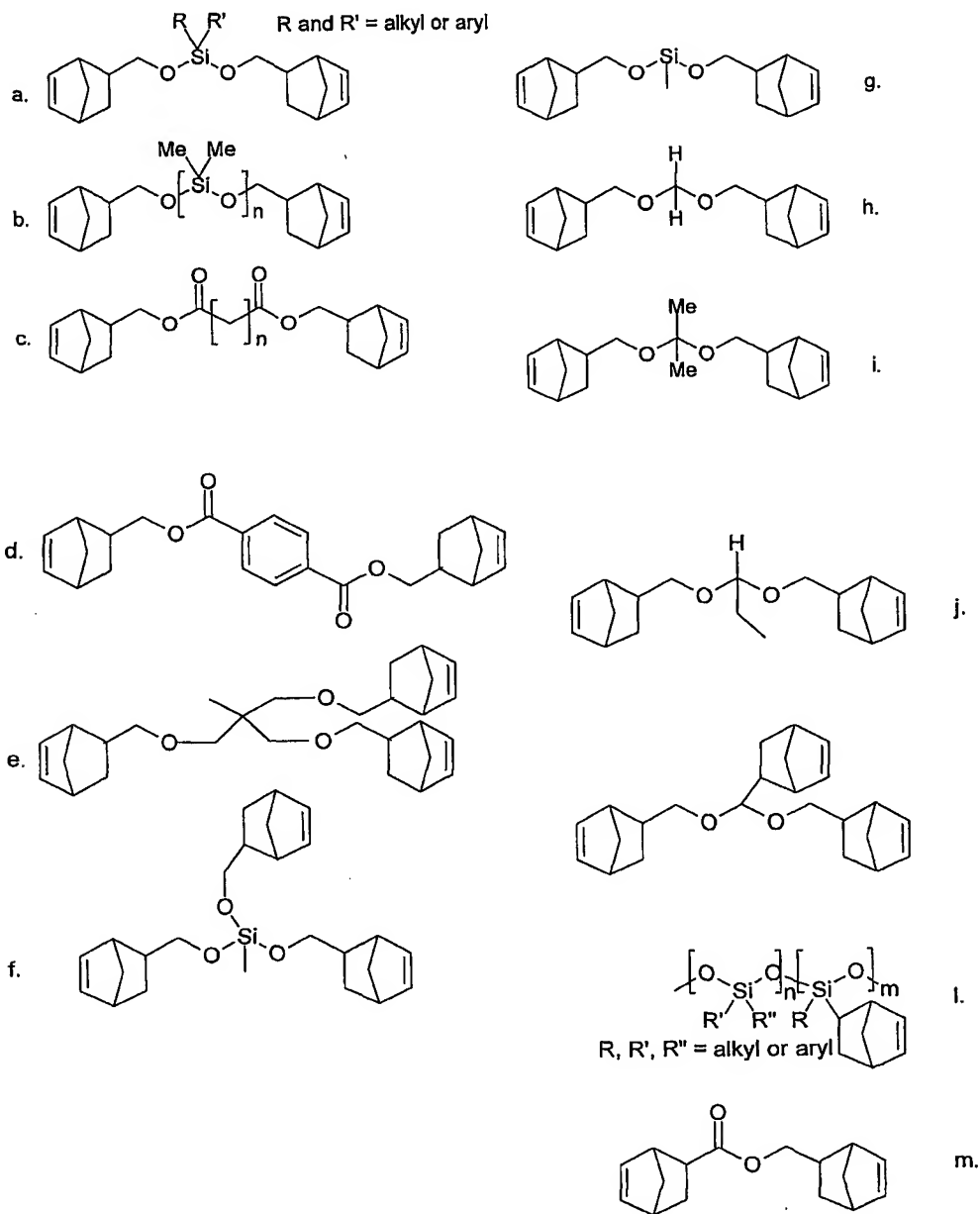
where n is 1 to 4.

17. The polymer composition of claim 15, wherein the crosslinking agent is selected from at least one of the following structures:



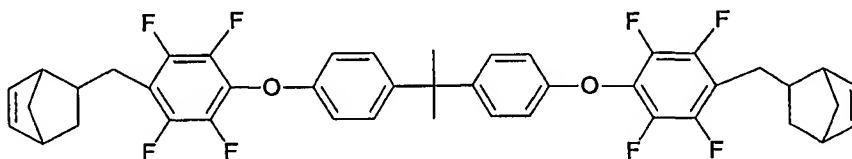


18. The polymer composition of claim 15, the crosslinking agent is selected from at least one of the following structures:

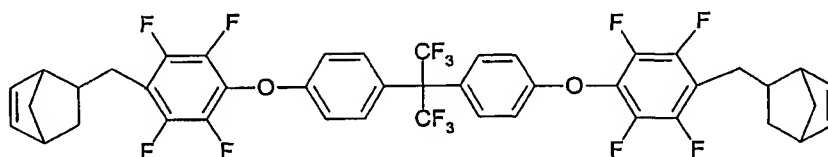


where m and n, if present, are independently an integer from 1 to 4.

19. The polymer composition of claim 15, the crosslinking agent is selected from at least one of the following structures:

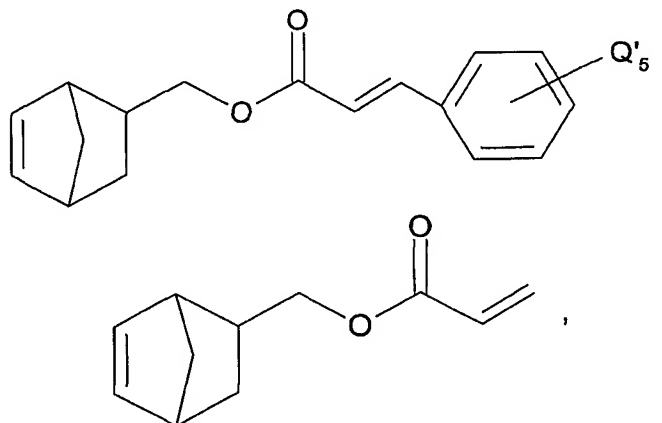


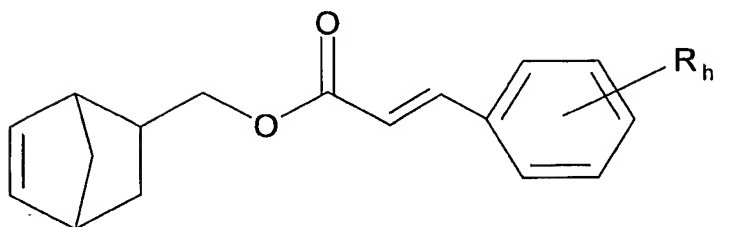
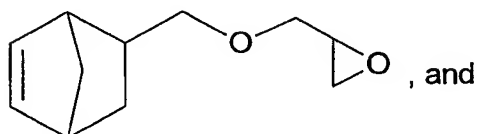
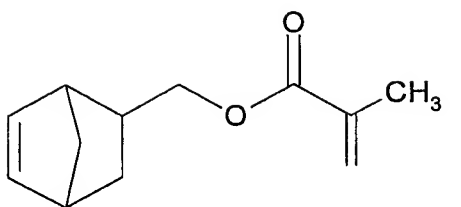
and



20. The composition of claim 15, wherein the crosslinking agent is a latent crosslinking agent.

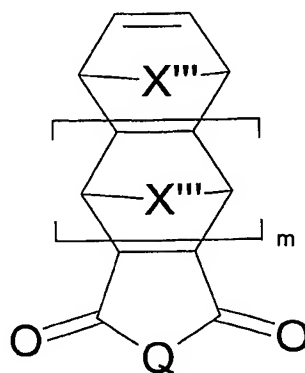
21. The composition of claim 20, wherein latent crosslinking agent is selected from one or more of the following compounds:





where R_h represents a non-halogenated, halogenated or perhalogenated group such as C_nQ'ⁿ, n is an integer from 1 to 10, and Q' represents a hydrogen or a halogen.

22. A polycyclic polymer composition formed from one or more monomers or oligomers represented by the following structure:



wherein each X''' independently represents oxygen, nitrogen, sulfur, or a methylene group of the formula $-(CH_2)_{n'}$ - where n' is an integer of 1 to 5; Q represents an oxygen atom or the group $N(R^8)$; R^8 is selected from hydrogen, a halogen, a linear or branched C_1 - C_{10} alkyl, and C_6 - C_{18} aryl; and m is an integer from 0 to 5.

23. The polymer composition of claim 22, wherein the composition is a homopolymer.

24. The polymer composition of claim 22, wherein the composition is a copolymer.

25. The polymer composition of claim 22, wherein X''' is nitrogen having a hydrogen or a C_1 to C_{10} alkyl group.

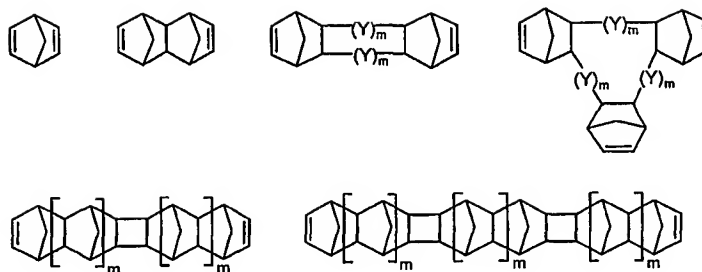
26. The polymer composition of claim 22, wherein the number of repeating units in the composition is from about 100 to about 100,000.

27. The polymer composition of claim 22, wherein the number of repeating units in the composition is from about 500 to about 50,000.

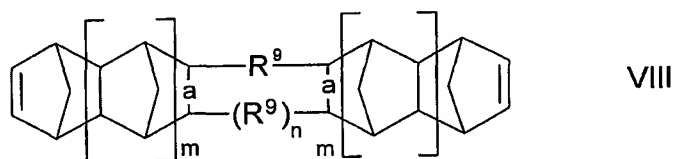
28. The polymer composition of claim 22, wherein the number of repeating units in the composition is from about 1,000 to about 10,000.

29. The polymer composition of claim 22, wherein the polymer composition is formed from one or more monomers or oligomers according to claim 22 in combination with one or more crosslinking agents.

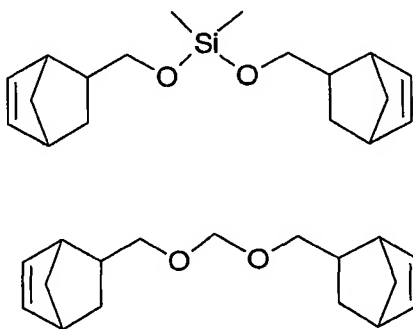
30. The composition of claim 29, wherein the at least one crosslinking agent is selected from one or more of the following compounds:

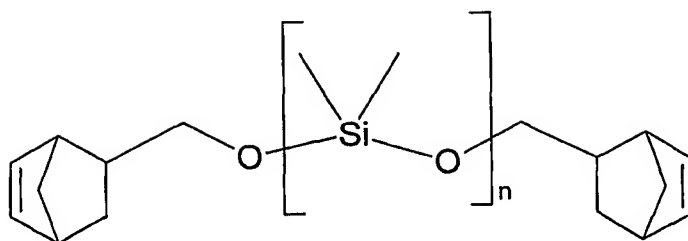


wherein Y represents a methylene ($-\text{CH}_2-$) group and m independently represents an integer from 0 to 5, and when m is 0, Y represents a single bond; a linked multicyclic crosslinking agent as shown in Structure VIII below:



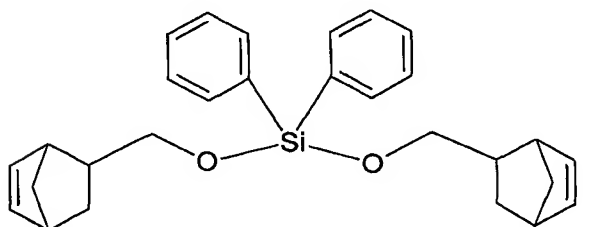
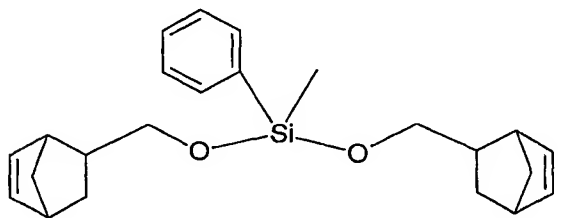
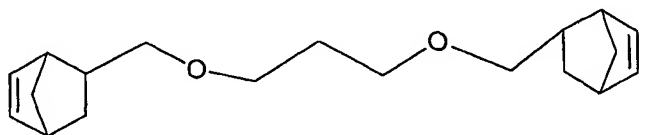
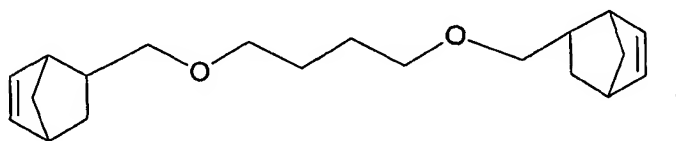
wherein "a" independently represents a single or double bond, m independently is an integer from 0 to 5, R^9 is a divalent radical selected from divalent hydrocarbyl radicals, divalent ether radicals and divalent silyl radicals, and n is 0 or 1; or a crosslinking agent as shown below:

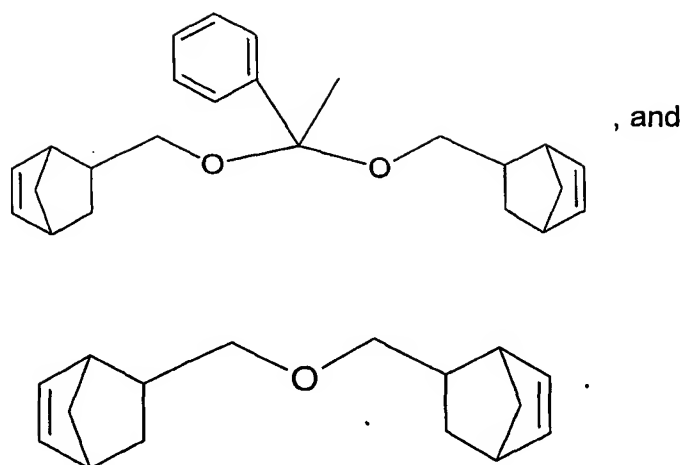




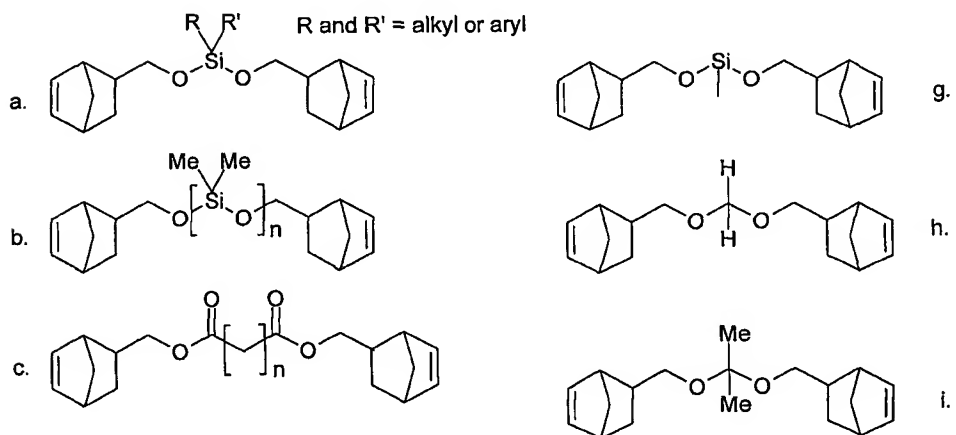
where n is 1 to 4.

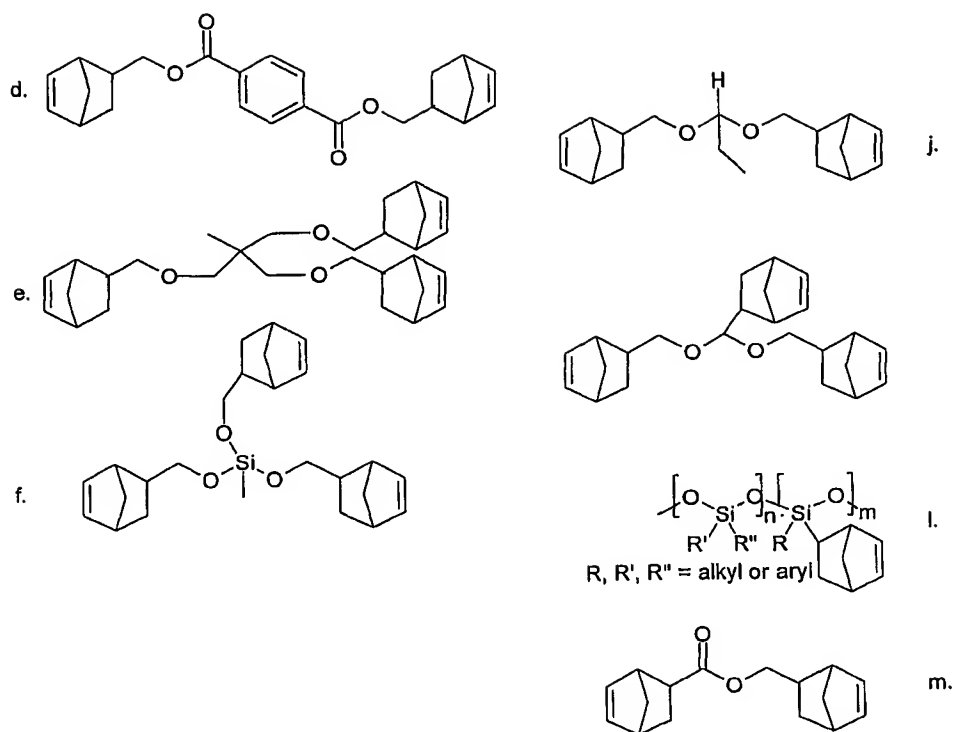
31. The polymer composition of claim 29, wherein the at least one crosslinking agent is selected from one or more of the following compounds:





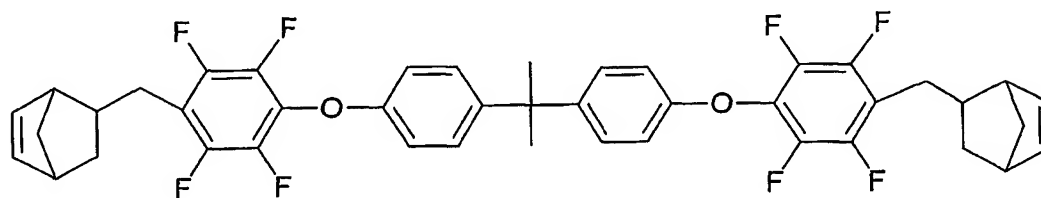
32. The polymer composition of claim 29, wherein the at least one crosslinking agent is selected from one or more of the following compounds:



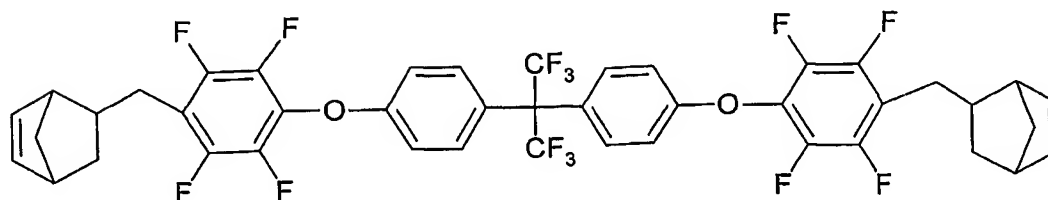


where m and n, if present, are independently an integer from 1 to 4.

33. The polymer composition of claim 29, wherein the at least one crosslinking agent is selected from one or more of the following compounds

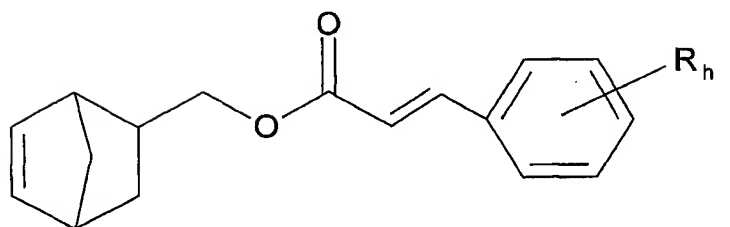
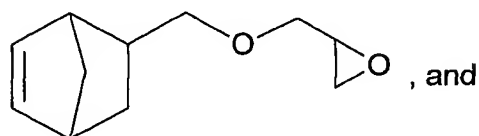
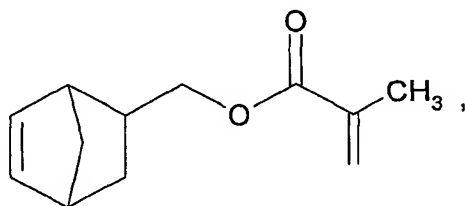
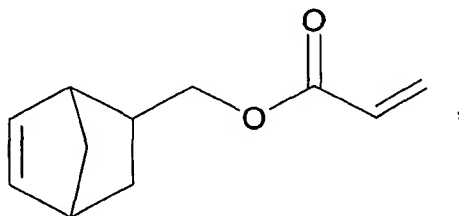
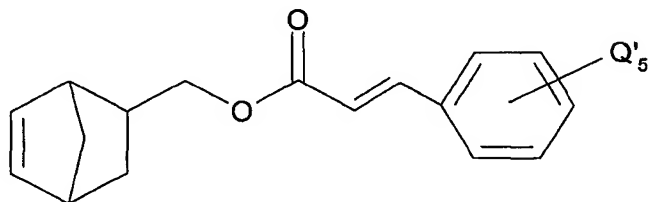


and



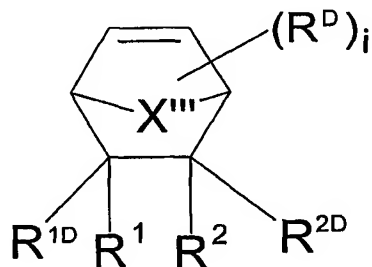
34. The composition of claim 29, wherein the crosslinking agent is a latent crosslinking agent.

35. The composition of claim 34, wherein latent crosslinking agent is selected from one or more of the following compounds:



where R_n represents a non-halogenated, halogenated or perhalogenated group such as C_nQ^{n+1} , n is an integer from 1 to 10, and Q represents a hydrogen or a halogen.

36. A polycyclic polymer composition formed from one or more monomers represented by the following structure:



wherein X''' represents oxygen, nitrogen, sulfur, or a methylene group of the formula $-(CH_2)_{n'}$ where n' is an integer of 1 to 5; R^D is deuterium, "i" is an integer ranging from 0 to 6, with the proviso that when "i" is 0, at least one of R^{1D} and R^{2D} must be present; R^1 and R^2 independently represent a hydrogen, a hydrocarbyl, or a functional substituent; and R^{1D} and R^{2D} , which are optional, independently represent a deuterium atom or a deuterium enriched hydrocarbyl group containing at least one deuterium atom.

37. The polymer composition of claim 36, wherein X''' is nitrogen having a hydrogen or a C_1 to C_{10} alkyl group.

38. The polymer composition of claim 36, wherein the number of repeating units in the composition is from about 100 to about 100,000.

39. The polymer composition of claim 36, wherein the number of repeating units in the composition is from about 500 to about 50,000.

40. The polymer composition of claim 36, wherein the number of repeating units in the composition is from about 1,000 to about 10,000.

41. The polymer composition of claim 36, wherein at least one of R^{1D} and R^{2D} are present and R^{1D} and R^{2D} are independently selected from linear or branched C_1 - C_{10} alkyl, wherein at least 40 percent of the hydrogen atoms on the carbon backbone are replaced by deuterium.

42. The polymer composition of claim 41, wherein both R^{1D} and R^{2D} are present.

43. The polymer composition of claim 36, wherein at least one of R^{1D} and R^{2D} are present and R^{1D} and R^{2D} are independently selected from a linear or branched C_1 - C_{10} alkyl, wherein at least 50 percent of the hydrogen atoms on the carbon backbone are replaced by deuterium.

44. The polymer composition of claim 43, wherein both R^{1D} and R^{2D} are present.

45. The polymer composition of claim 36, wherein at least one of R^{1D} and R^{2D} are present and R^{1D} and R^{2D} are independently selected from a linear or branched C_1 - C_{10} alkyl, wherein at least 60 percent of the hydrogen atoms on the carbon backbone are replaced by deuterium.

46. The polymer composition of claim 36, wherein both R^{1D} and R^{2D} are present.

47. The polymer composition of claim 36, wherein the polymer composition is formed in combination with at least one crosslinking agent.

48. The polymer composition of claim 36, wherein the polymer composition is formed from a combination of (A) one or more monomers according to claim 30 with (B) one or more oligomers derived from the monomers of claim 30

49. A polymer composition according to claim 1 for use in waveguides.

50. A polymer composition according to claim 22 for use in waveguides.

51. A polymer composition according to claim 36 for use in waveguides.

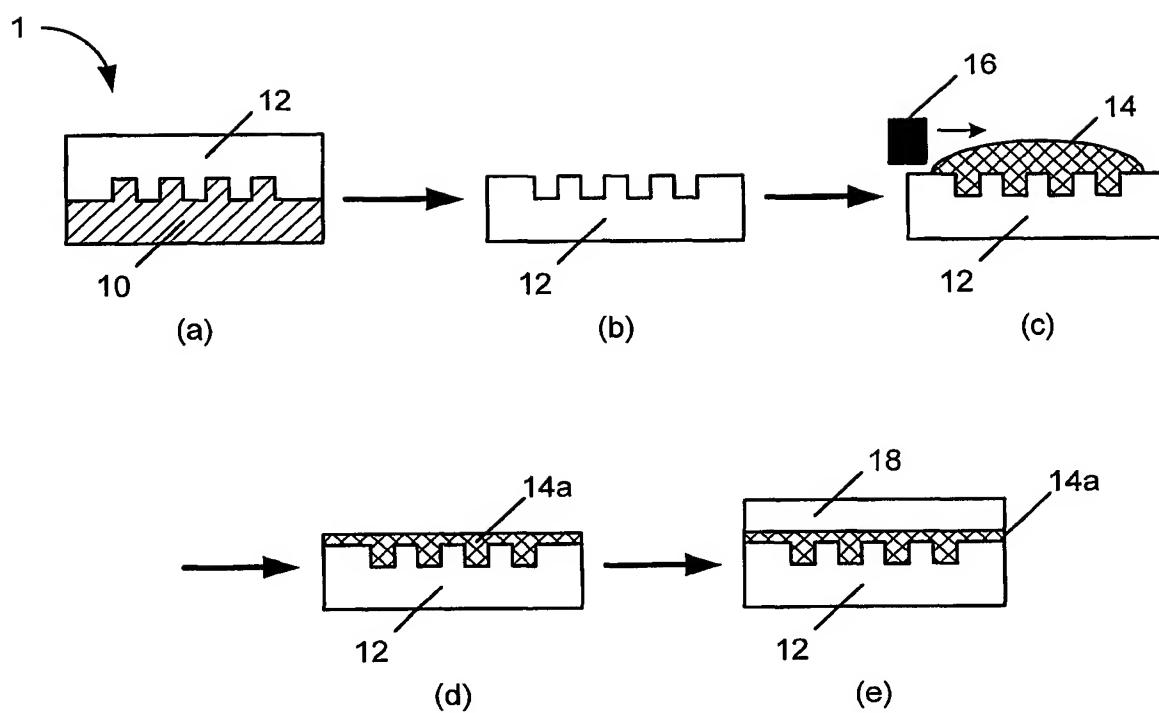


FIG. 1

Three-layer rib waveguides

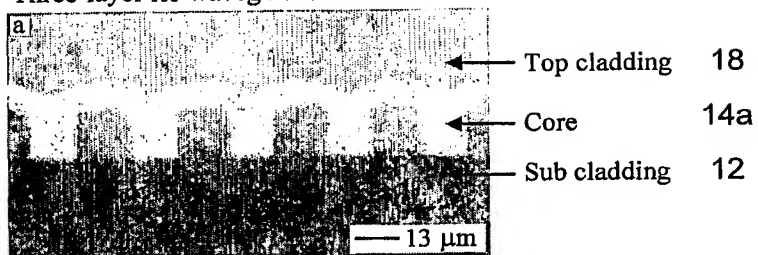


FIG. 2A

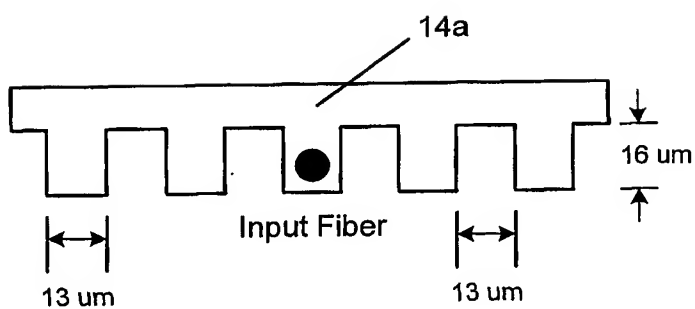


FIG. 2B

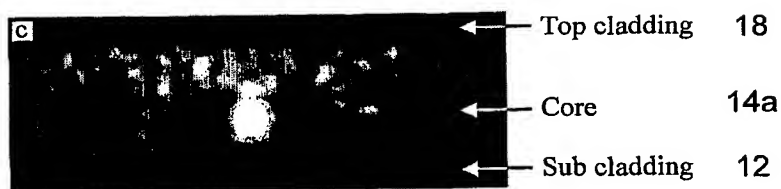


FIG. 2C

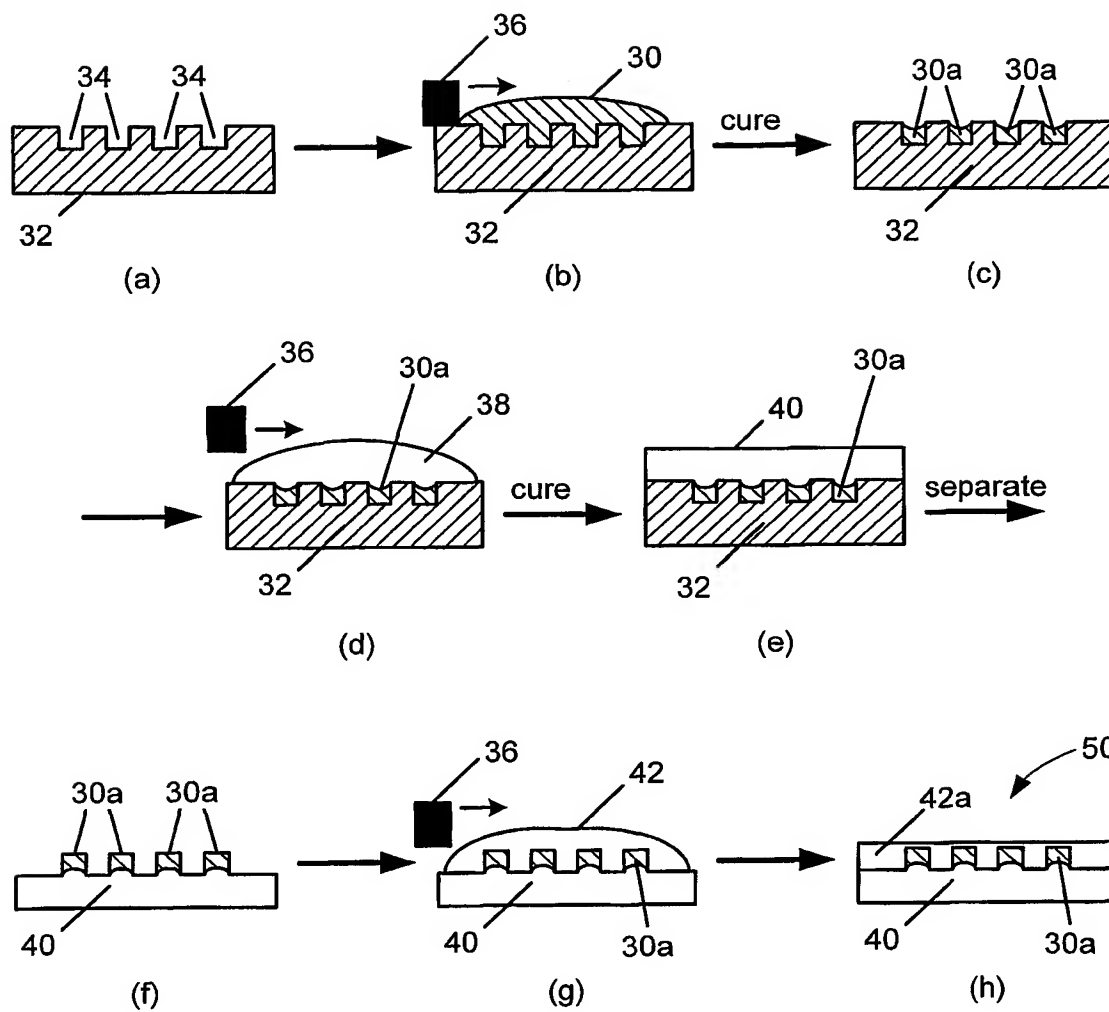


FIG. 3

4/9

Two-layer waveguides

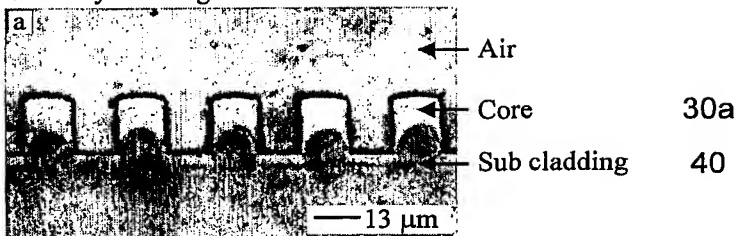


FIG. 4A

Three-layer waveguides

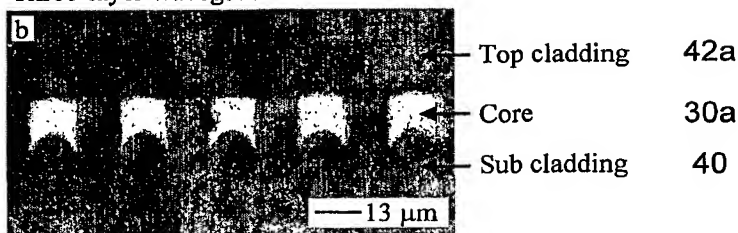


FIG. 4B

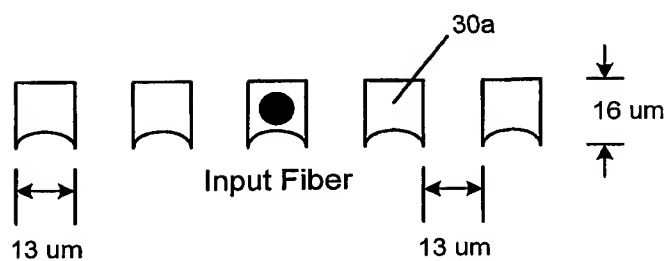


FIG. 4C

Output

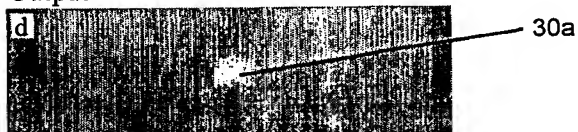


FIG. 4D

Clad-first

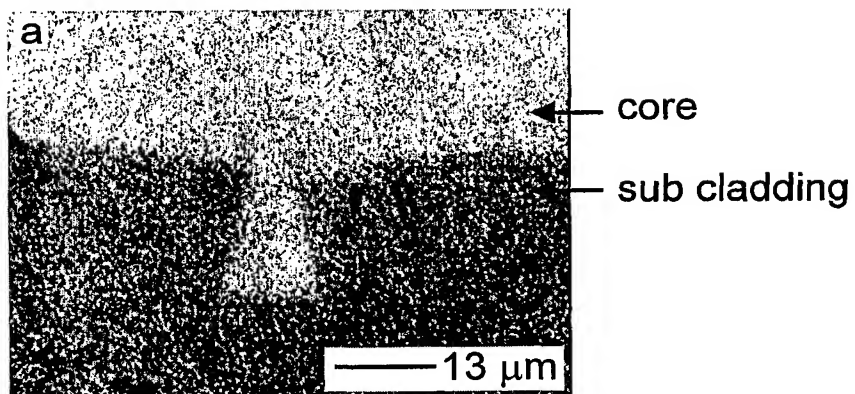


FIG. 5A

Core-first

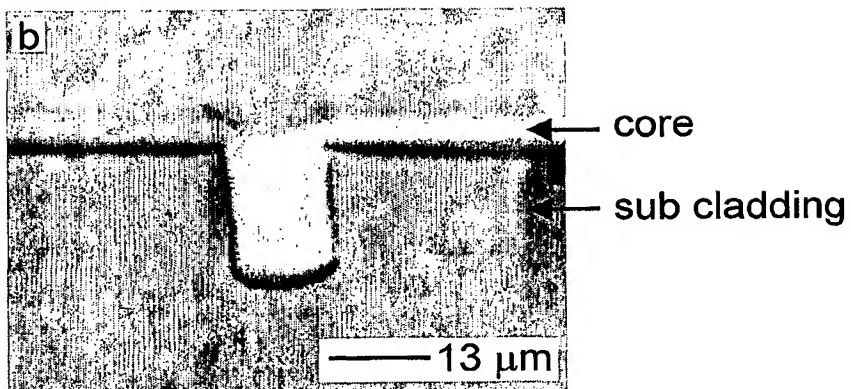


FIG. 5B

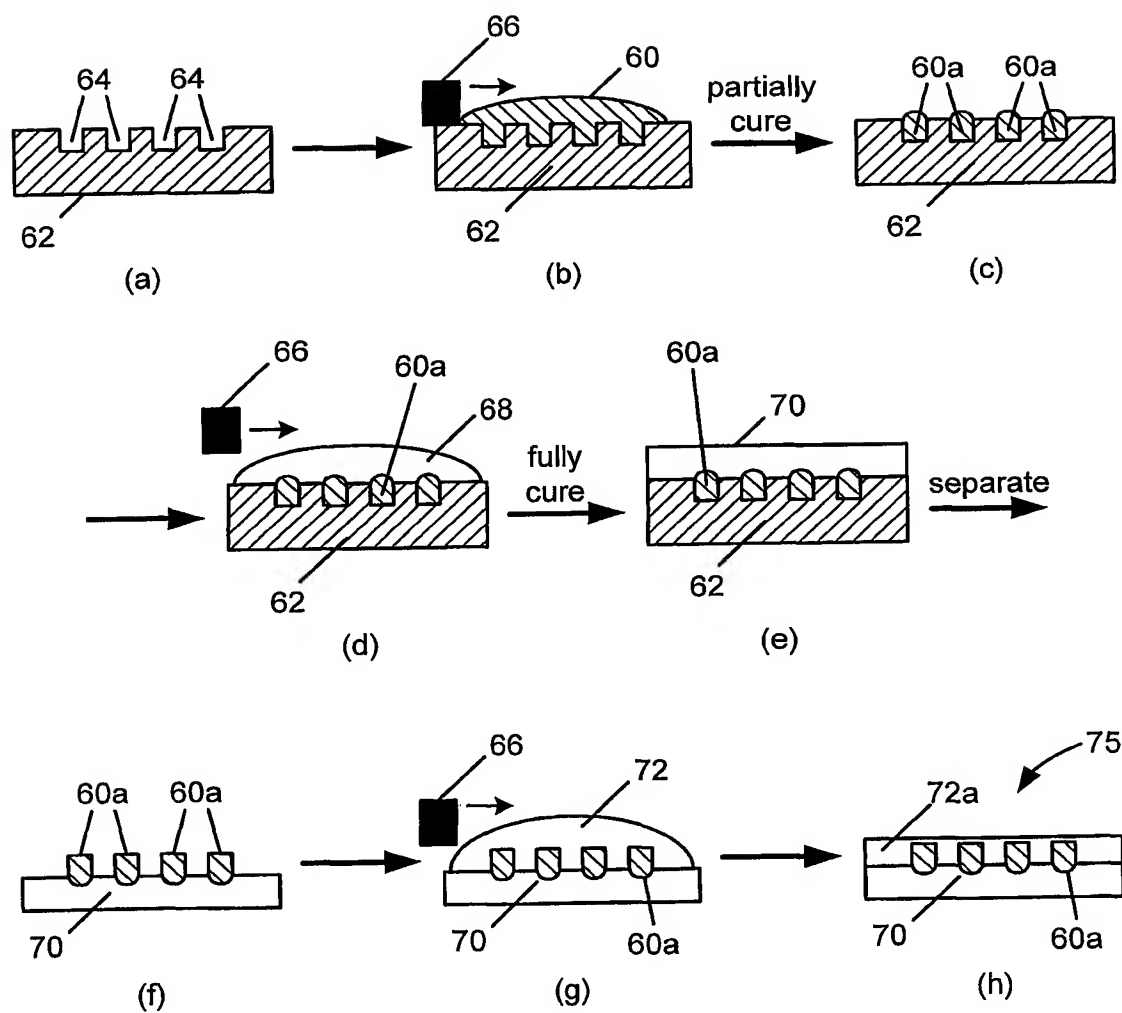


FIG. 6

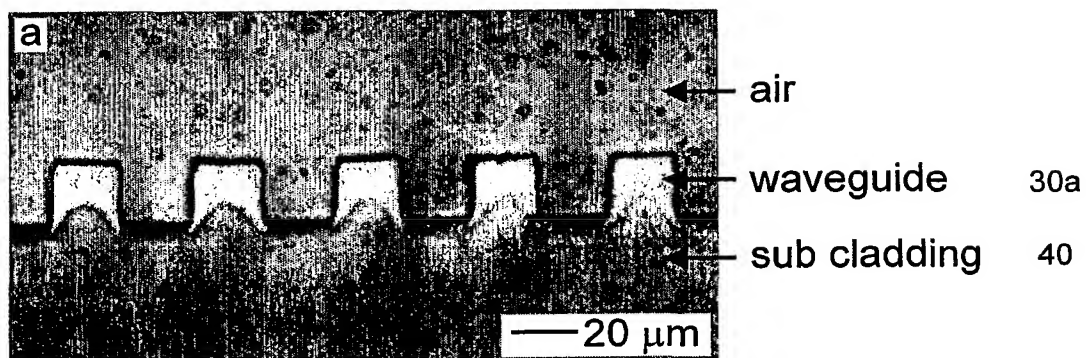


FIG. 7A

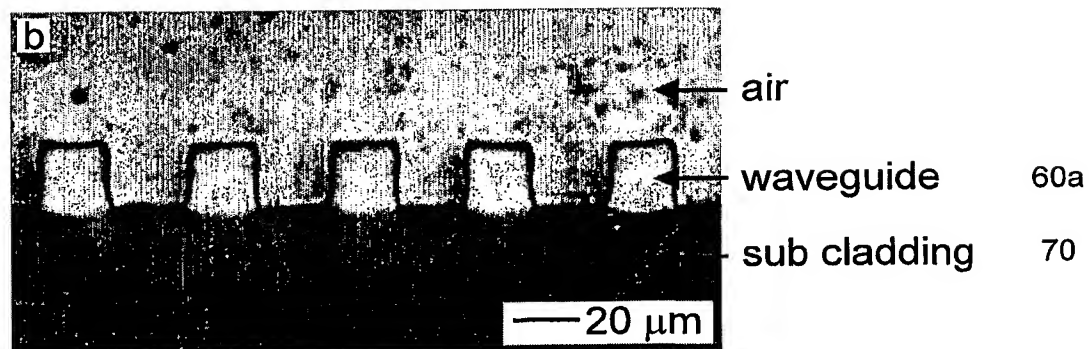


FIG. 7B

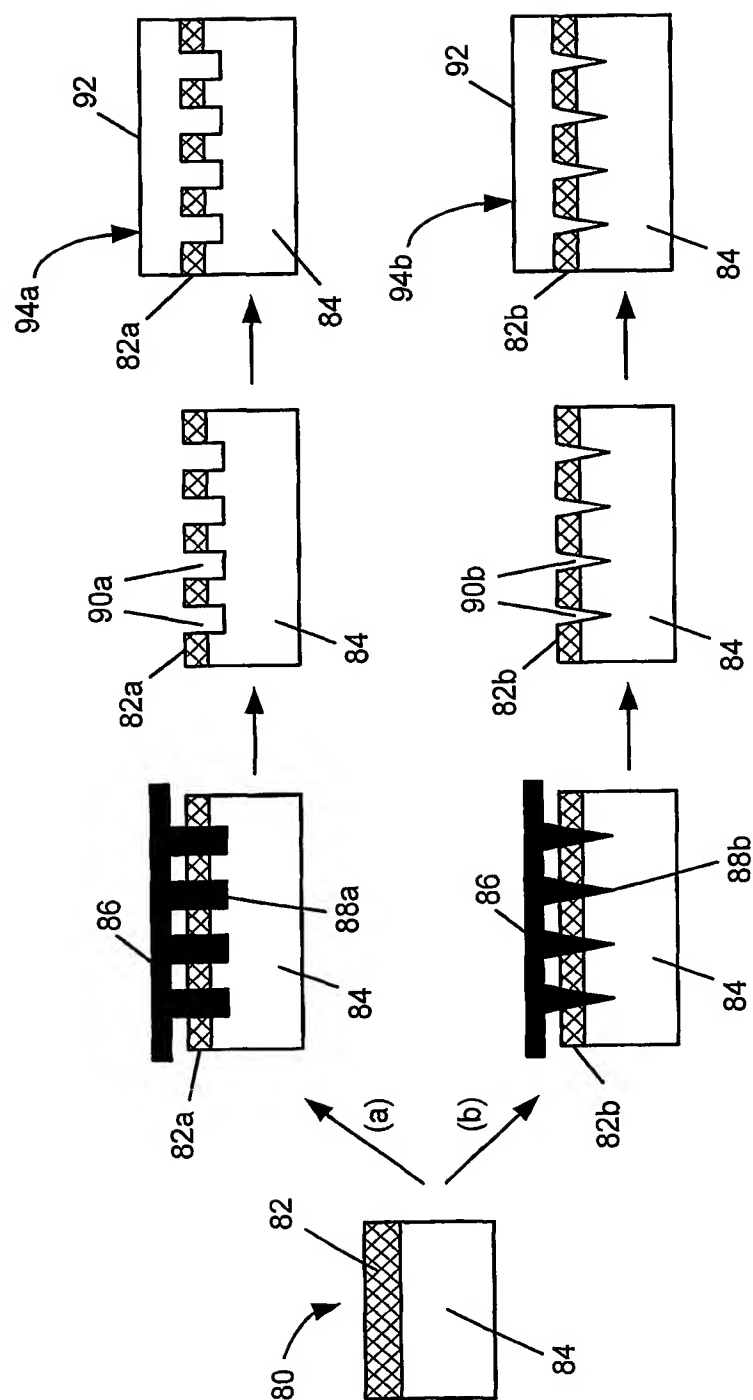


FIG. 8

FIG. 9A

Two-layer waveguides

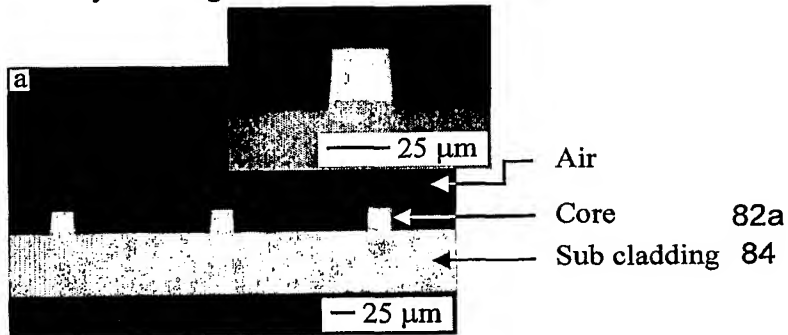


FIG. 9B

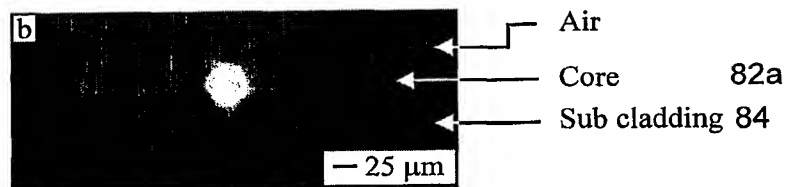


FIG. 9C

Three-layer waveguides

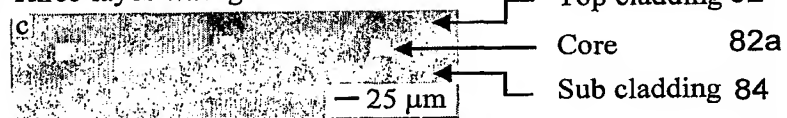


FIG. 9D

